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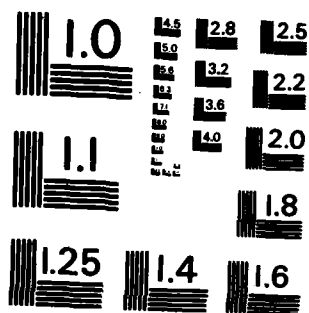
PROCESS PARAMETERS FOR BANDING 155-MM M483A1
PROJECTILES IN HIGH-CAPACITY... (U) CHAMBERLAIN MFG CORP
WATERLOO IA RESEARCH AND DEVELOPMENT DIV... SEP 82
C8184-PR-072-APP-B ARLCD-CR-82028-APP-B F/G 19/1

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MICROCOPY RESOLUTION TEST CHART
NATIONAL BUREAU OF STANDARDS-1963-A

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APPENDIX B

AD E400934

ULTRASONIC SCANNING TAPES GENERATED
BY CHAMBERLAIN AND AMMRC IN CONNEC-
TION WITH QUASI-PRODUCTION RUN OF IN-
ERTIA WELDED ROTATING BANDS ONTO
M483A1 PROJECTILES.

(1)



US ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
LARGE CALIBER
WEAPON SYSTEMS LABORATORY
DOVER, NEW JERSEY

This document is submitted as a supplement to
Contractor Report ARLCD-CR-82028, the Final
Technical Report for Contract DAAK10-79-C0083,
"Process Parameters for Banding 155-mm, M483A1
Projectiles in High Capacity Inertia Welding Machine."

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September 1982

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PREFACE

The ultrasonic scanning tapes presented in this appendix were generated in connection with a quasi-production run of 261 each M483A1 Projectiles with inertia welded rotating bands. The bands were welded during the period 2 February through 13 March 1961 at Chamberlain's New Bedford Division.

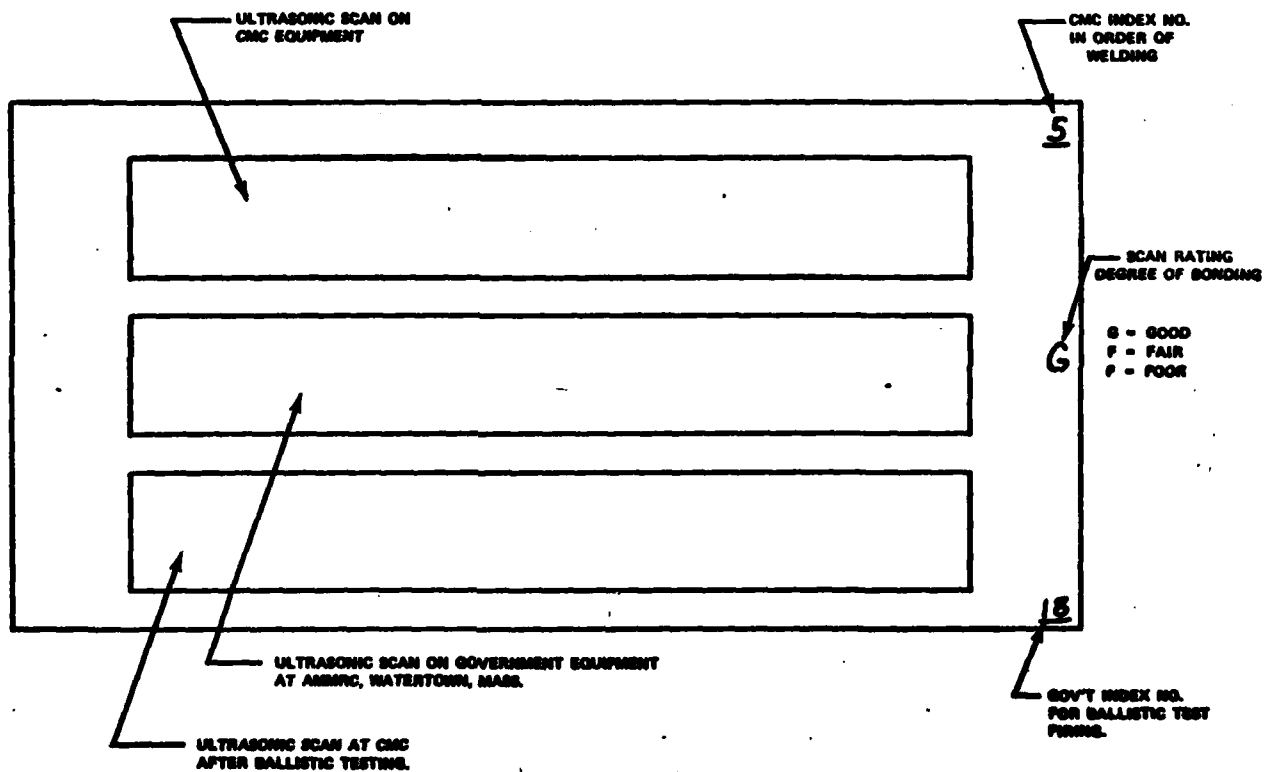
Of the 261 projectiles involved in the quasi-production run, 120 were selected for test firing at Aberdeen Proving Ground. Ultrasonic scans of these 120 projectiles are presented in this appendix in the following quantities:

SCANS GENERATED	QUANTITY
On CMC equipment before ballistic testing	120
On ANMEC equipment before ballistic testing	90
On CMC equipment after ballistic testing	15

A legend explaining how the scanning tapes are to be identified appears on the next page.

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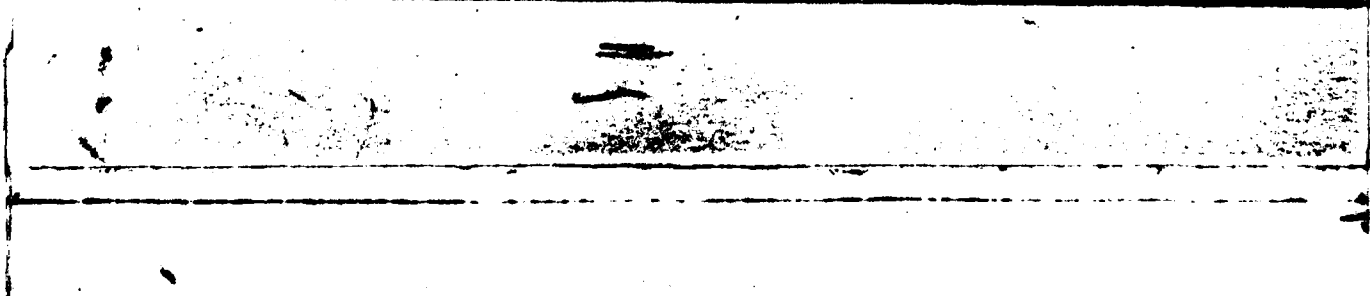
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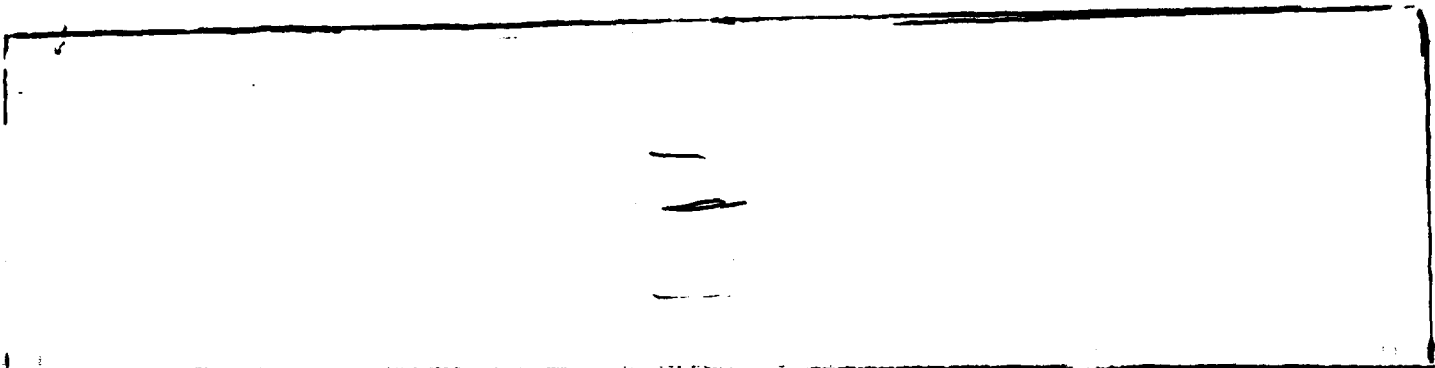
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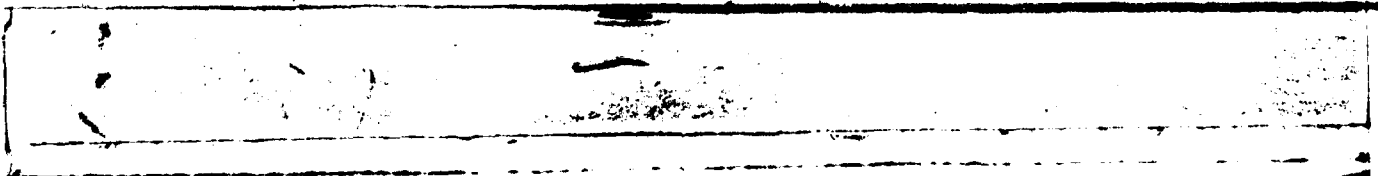


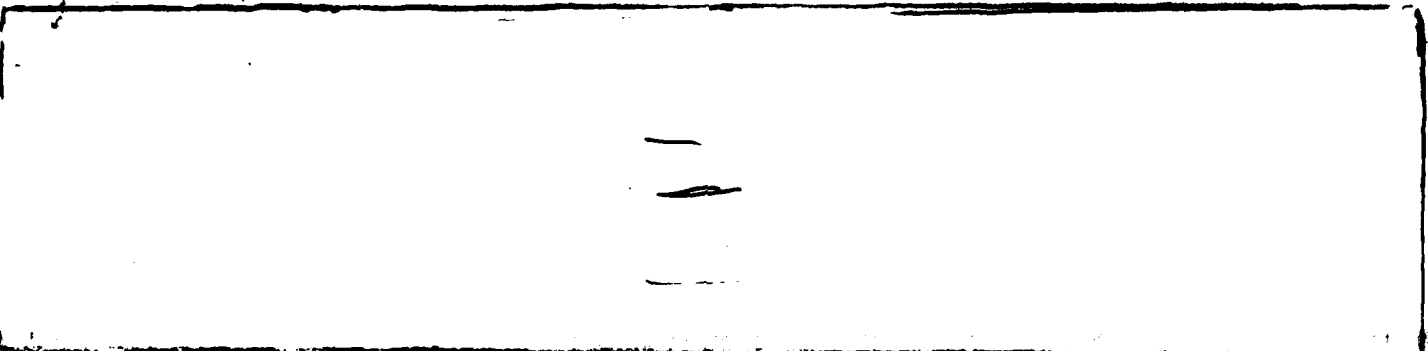
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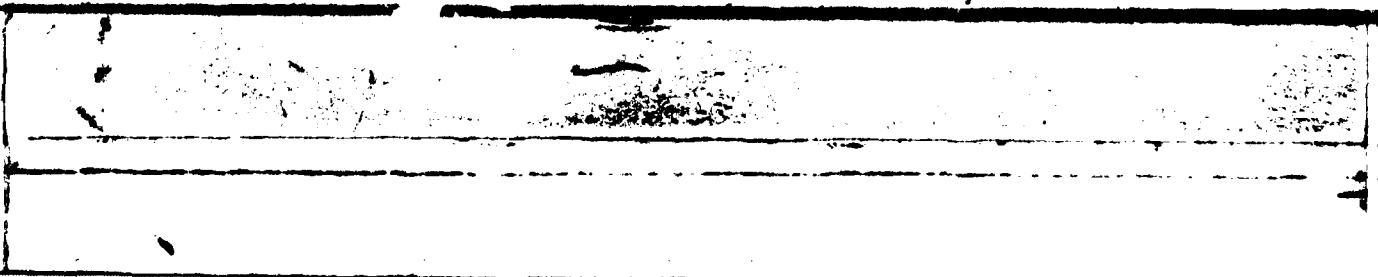
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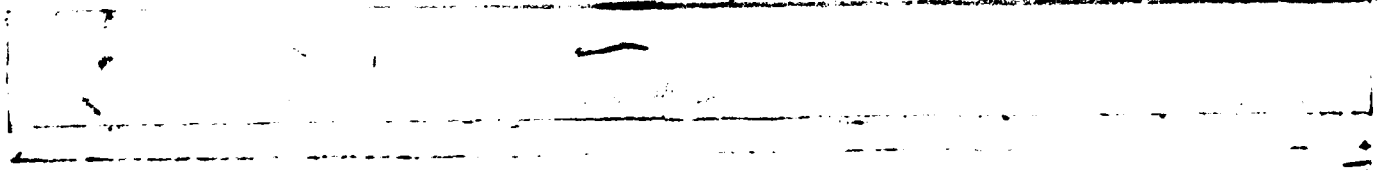
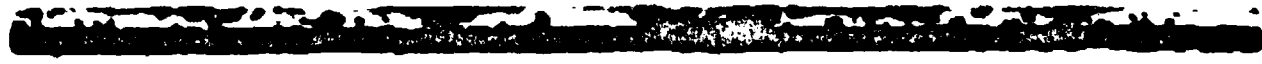
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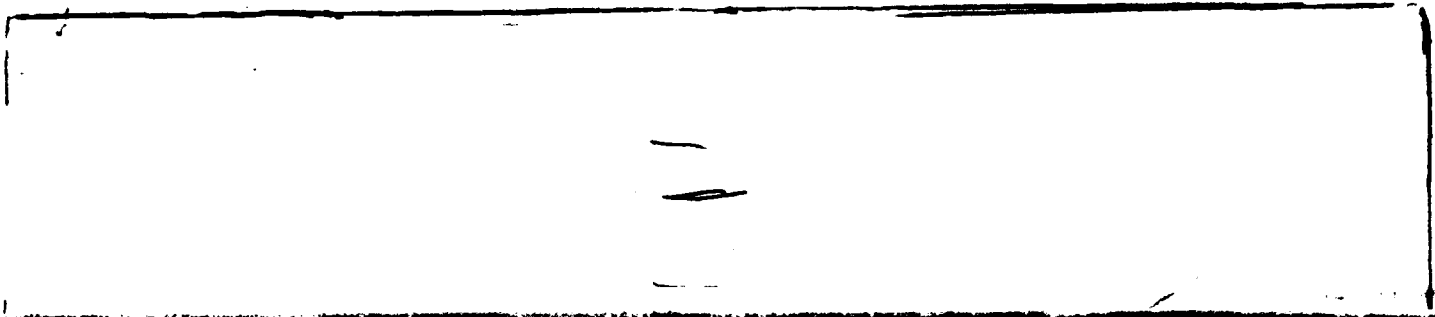


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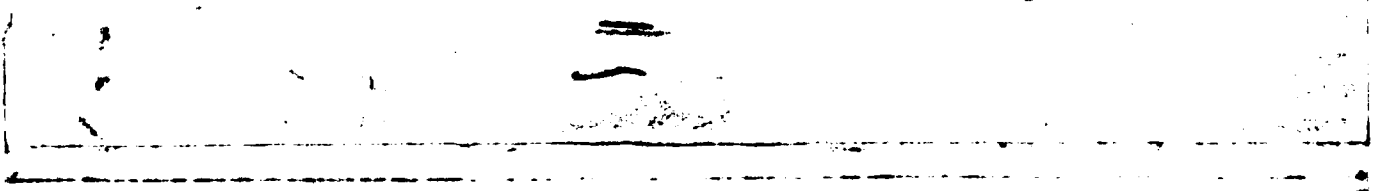
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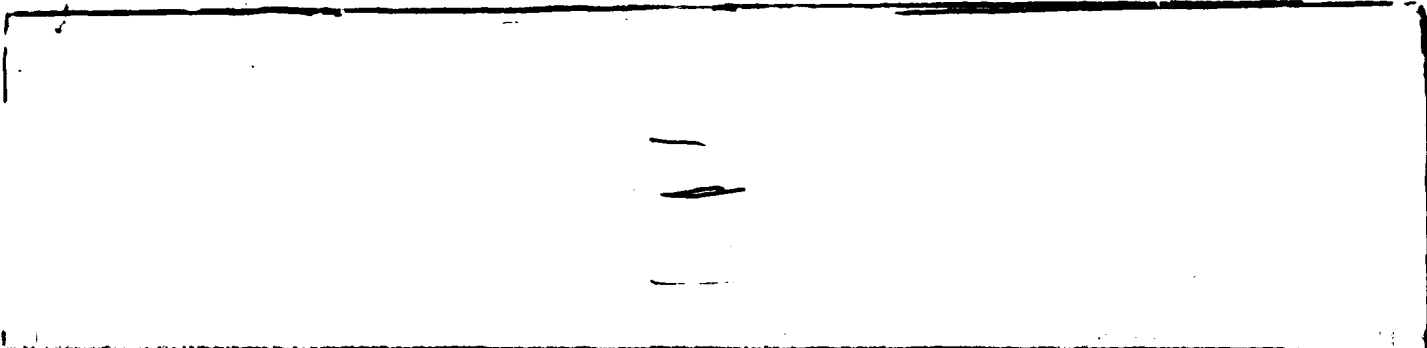


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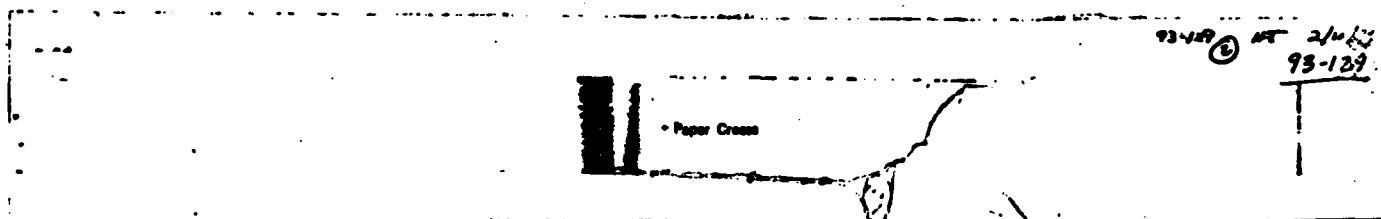
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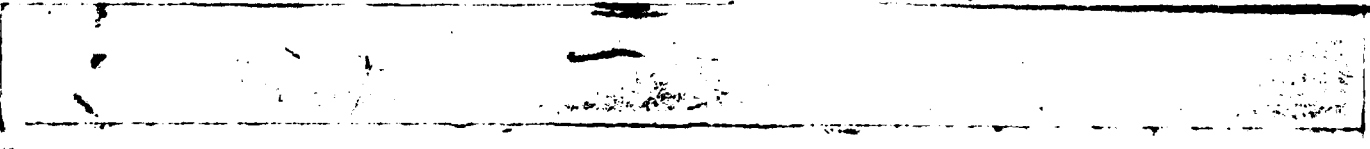
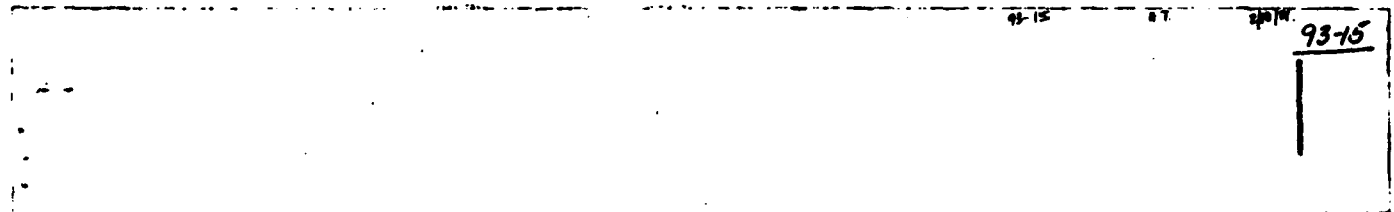
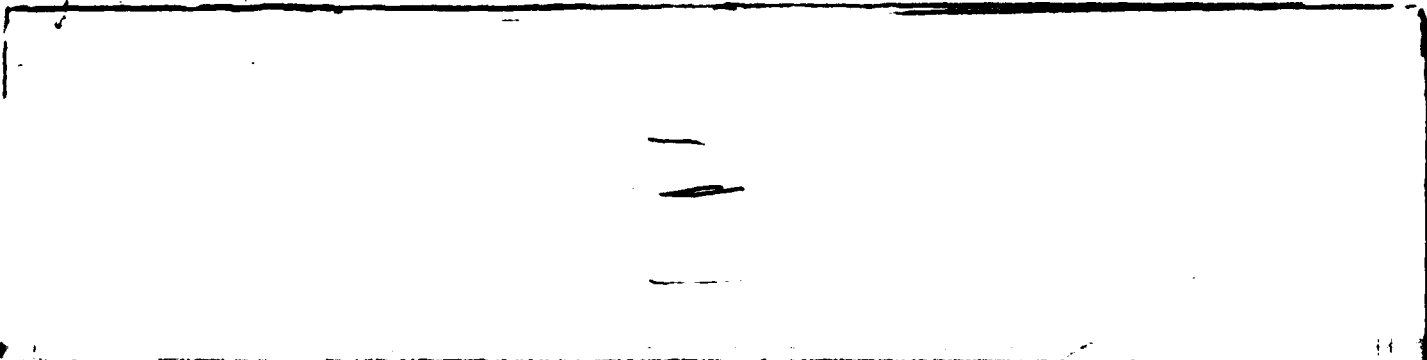
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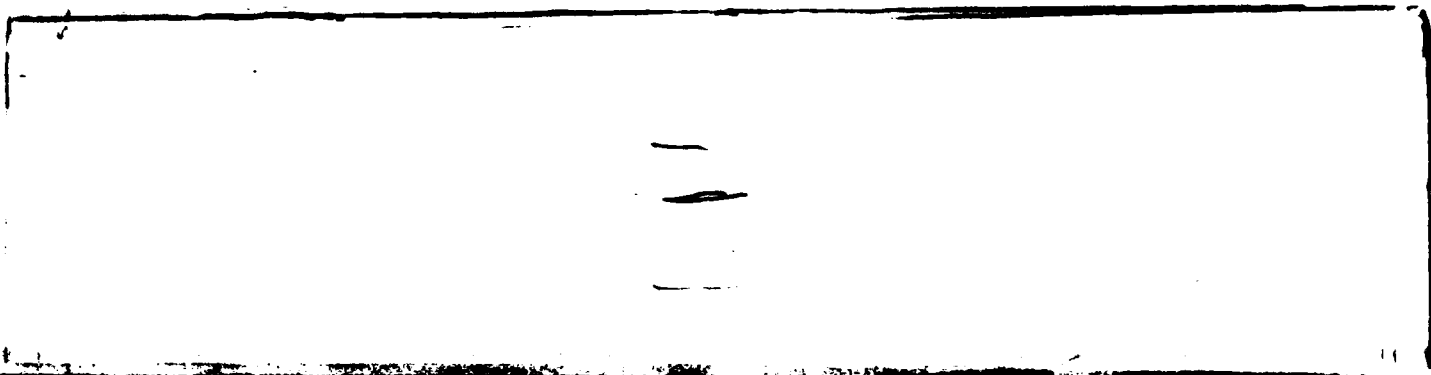




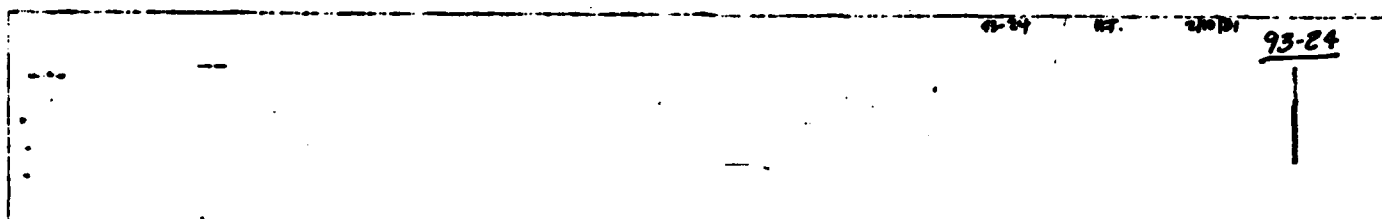
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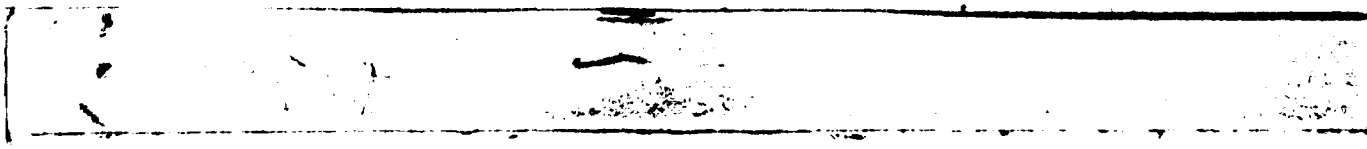
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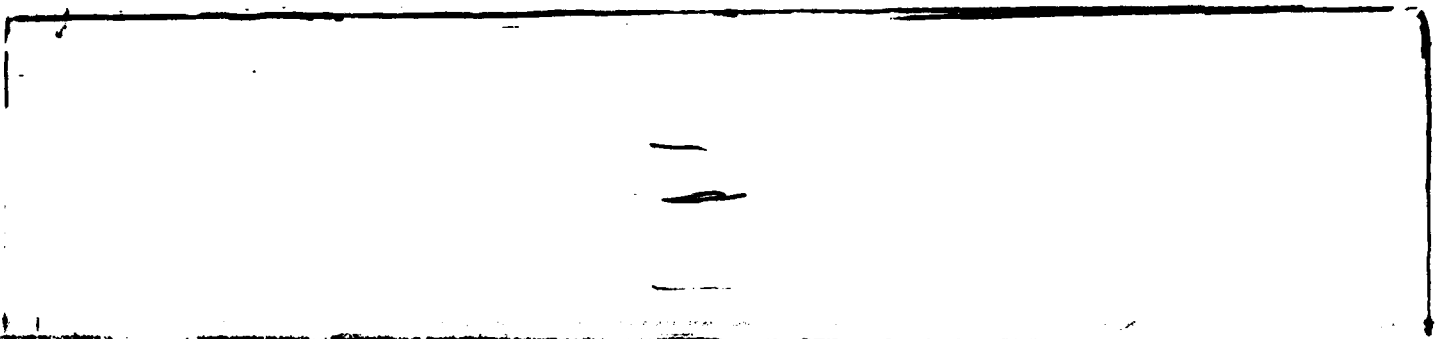


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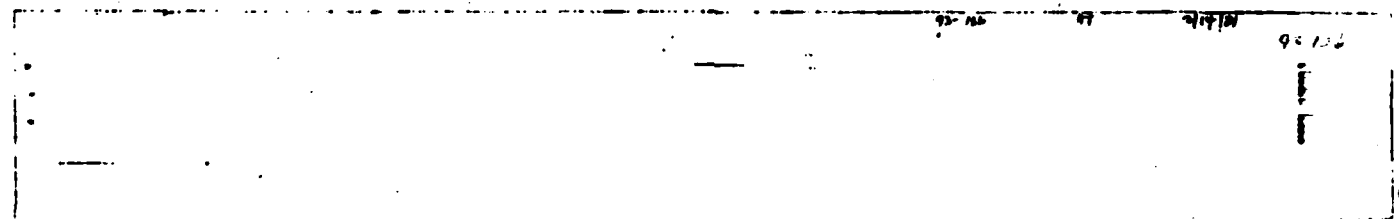


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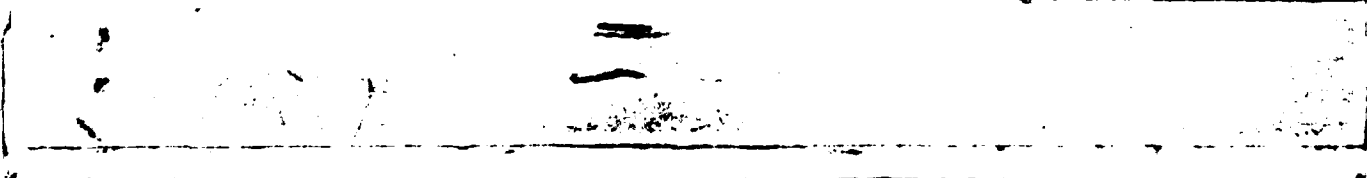




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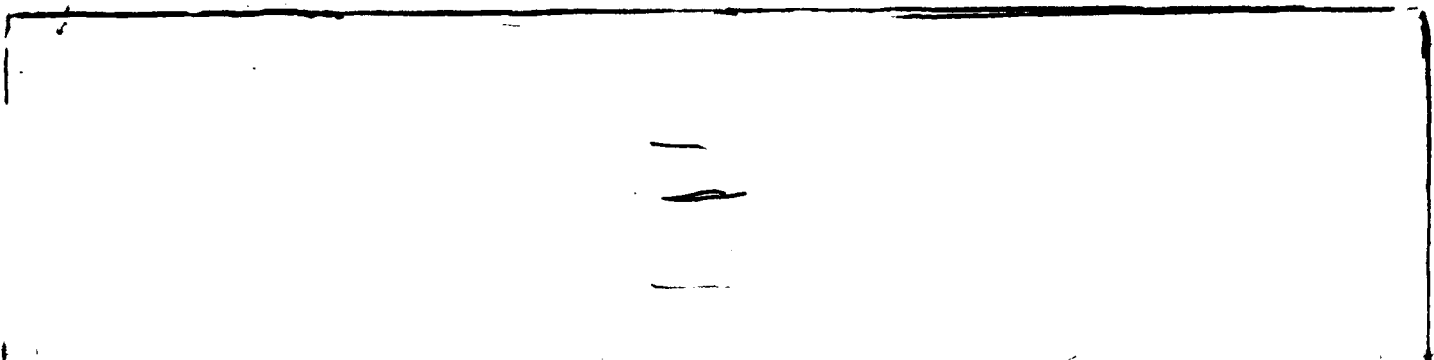
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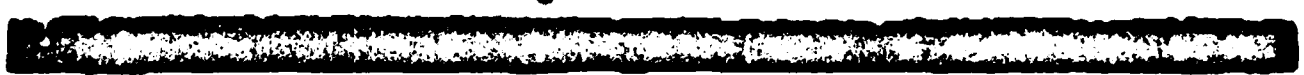
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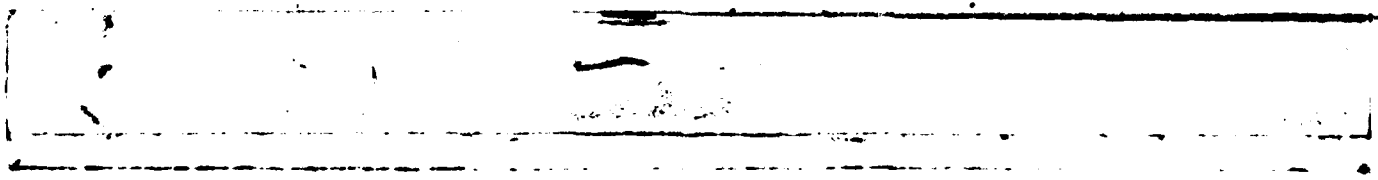
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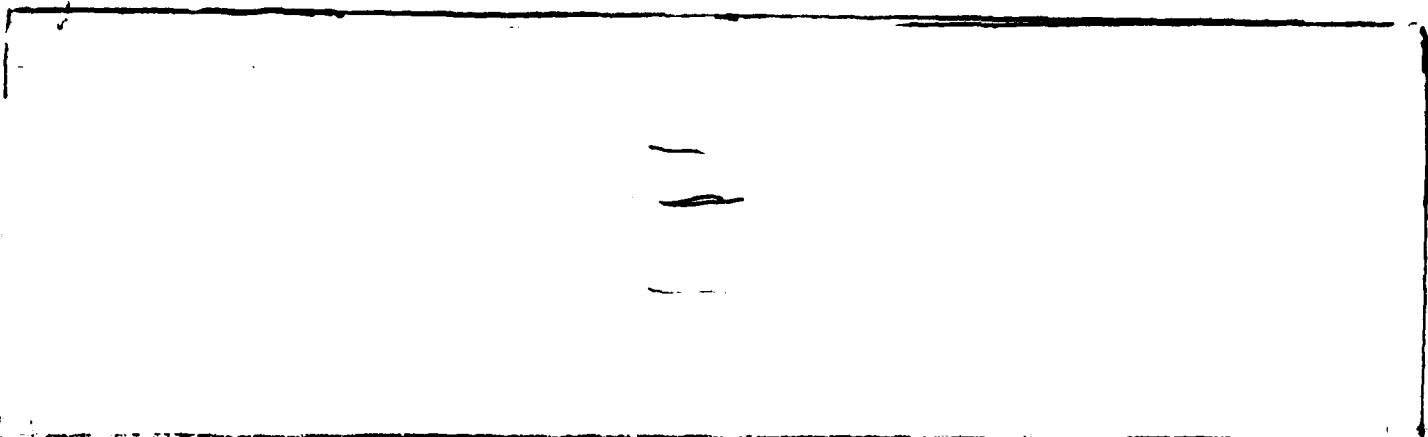
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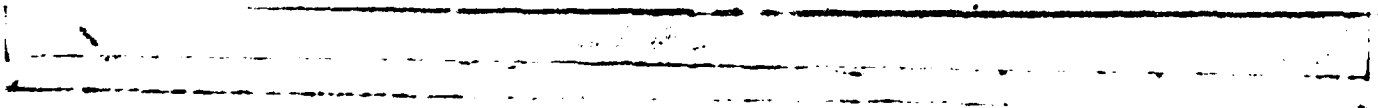
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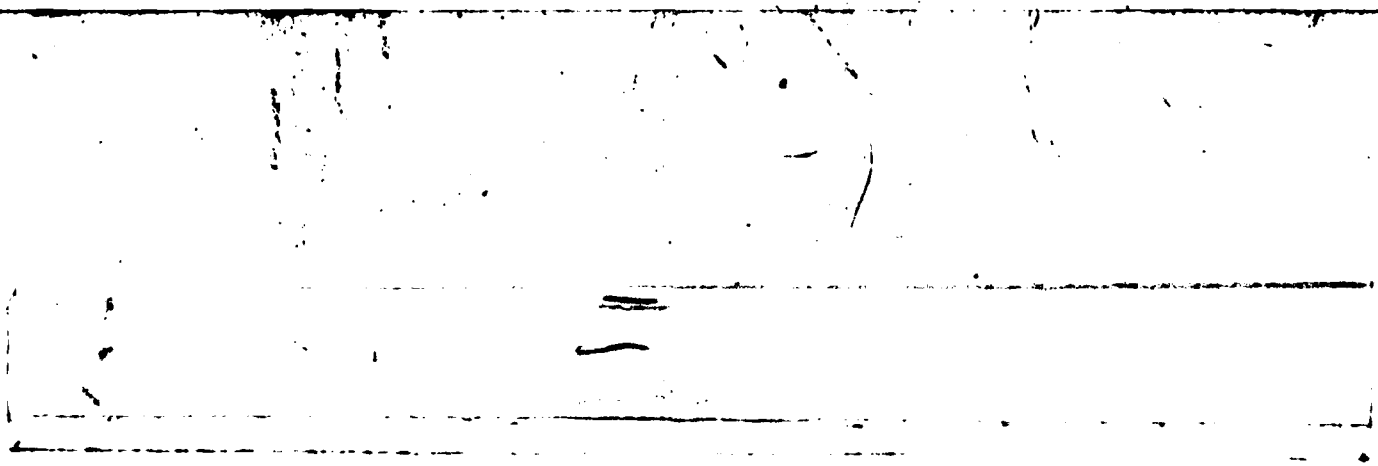


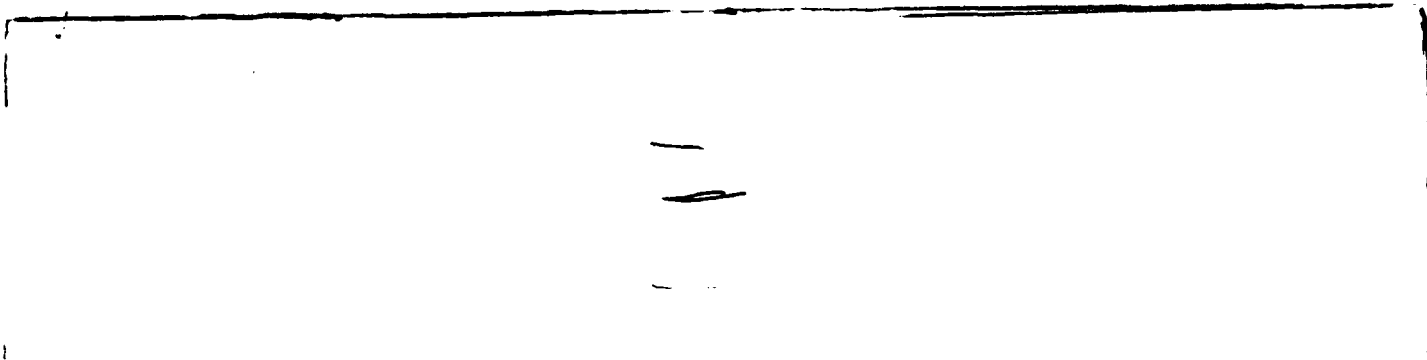
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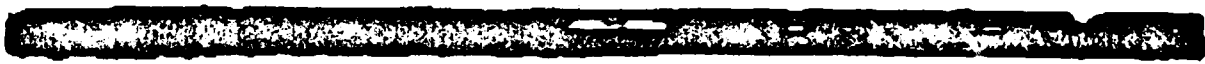
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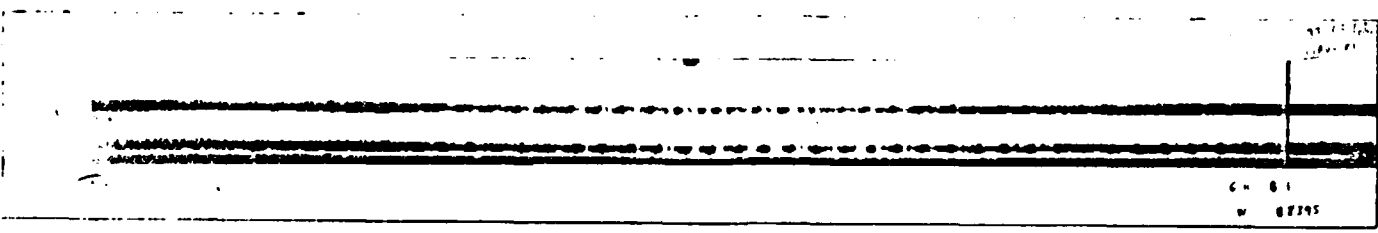


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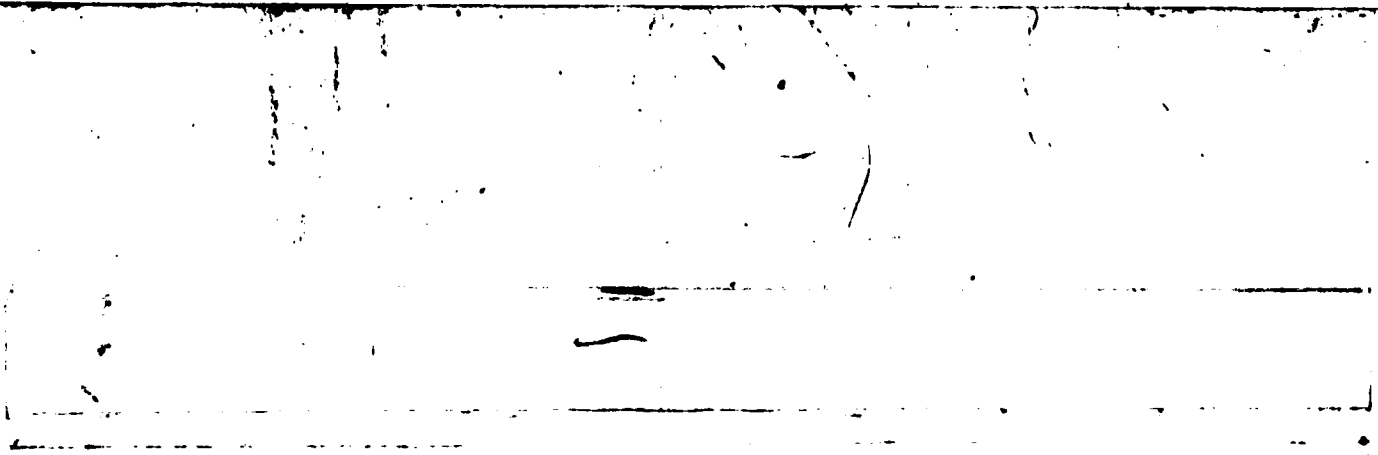


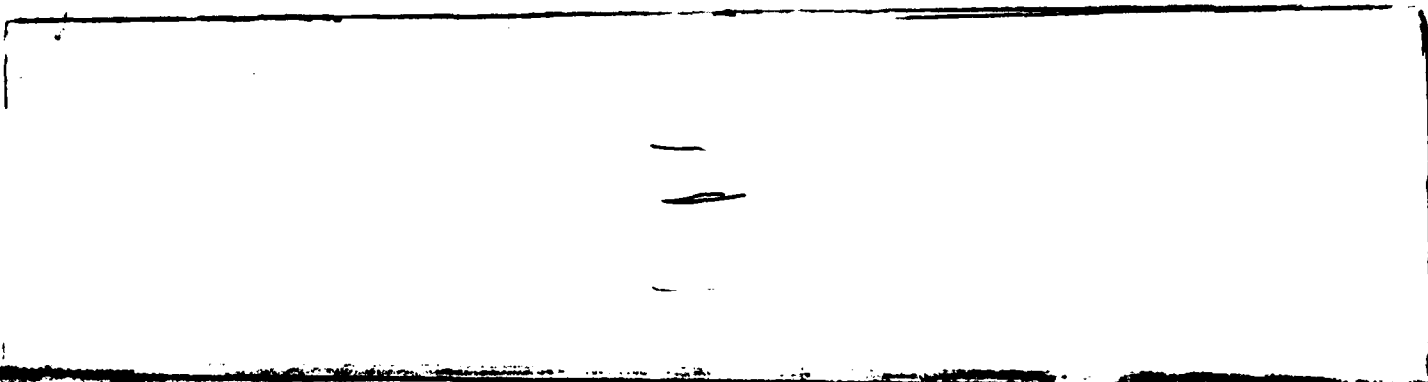
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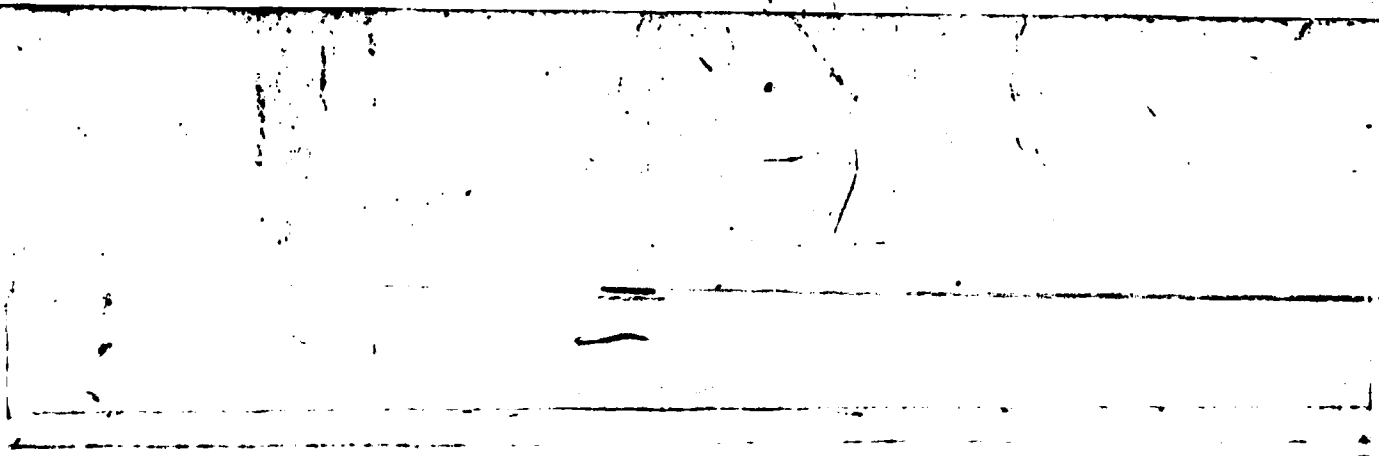
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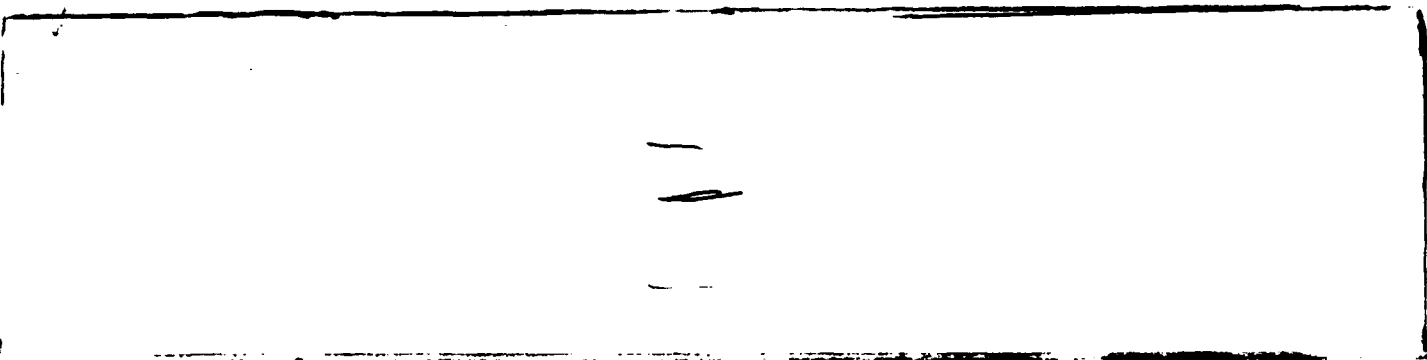
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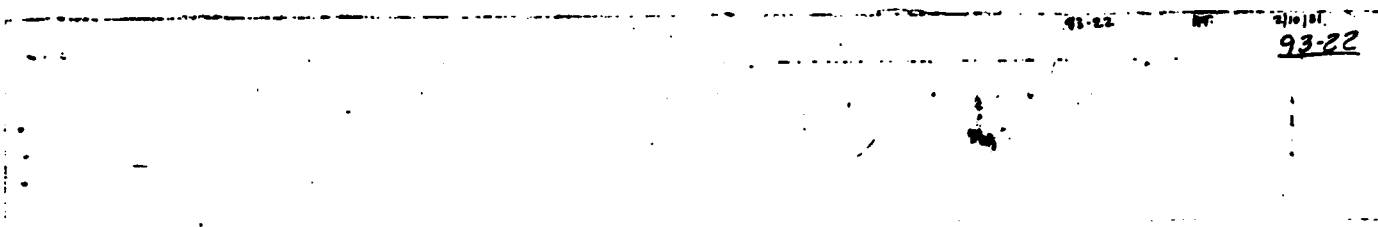
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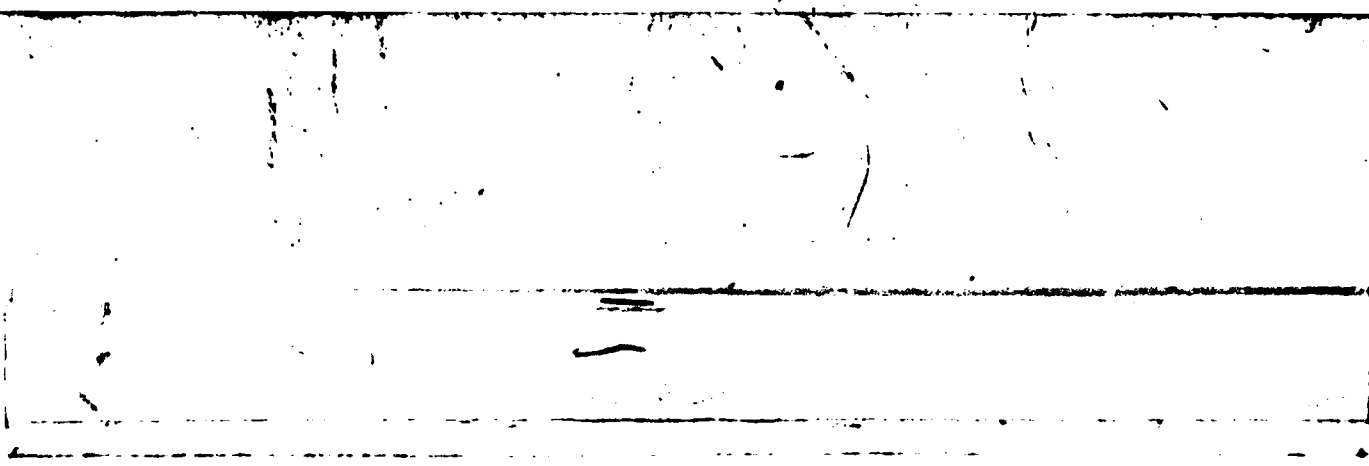
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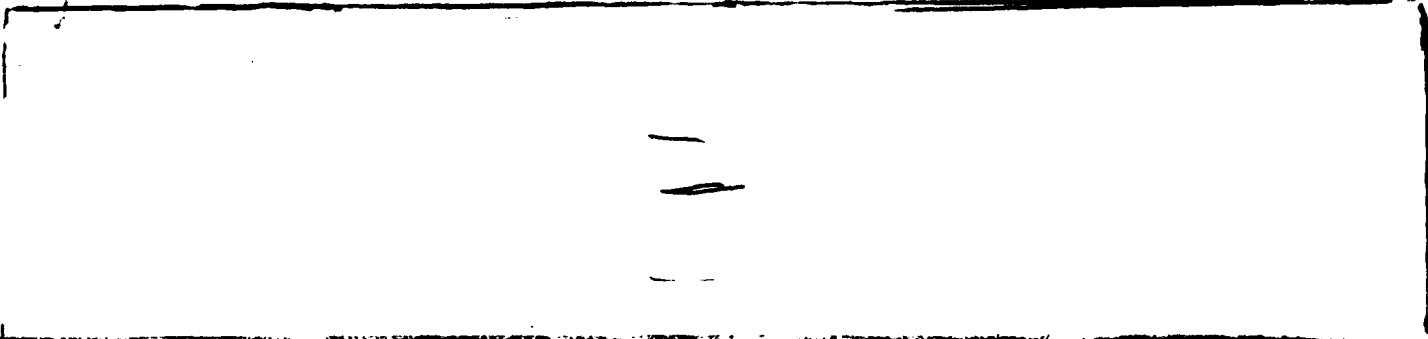


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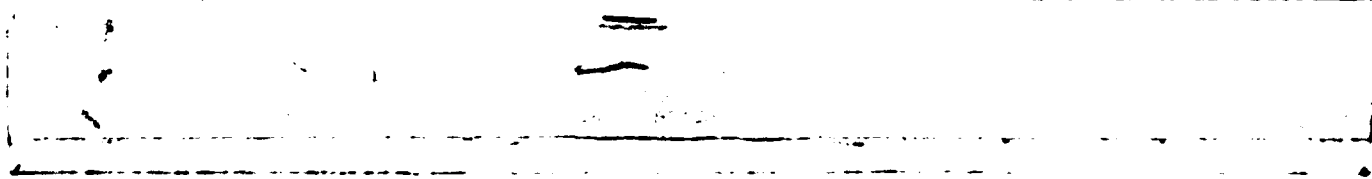
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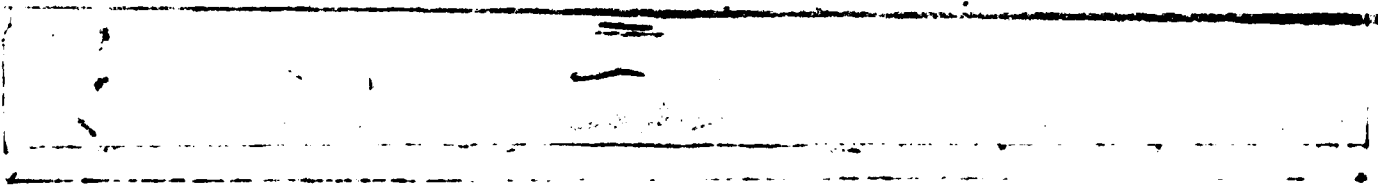
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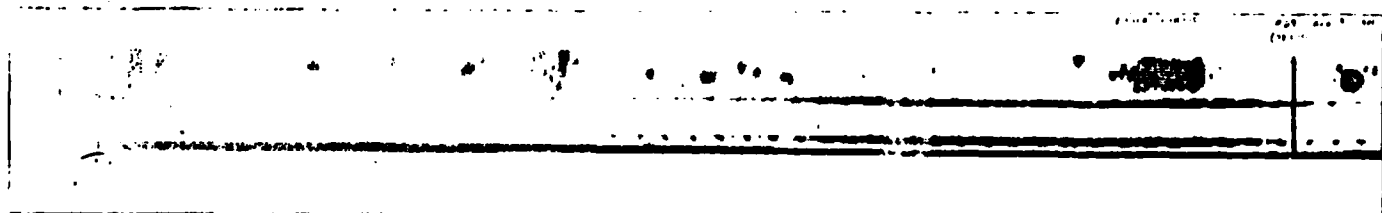
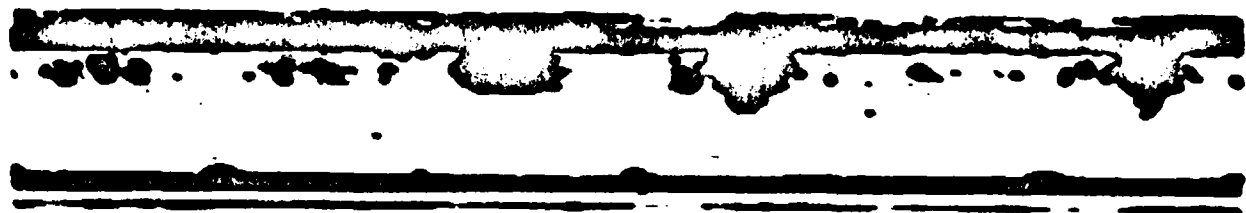




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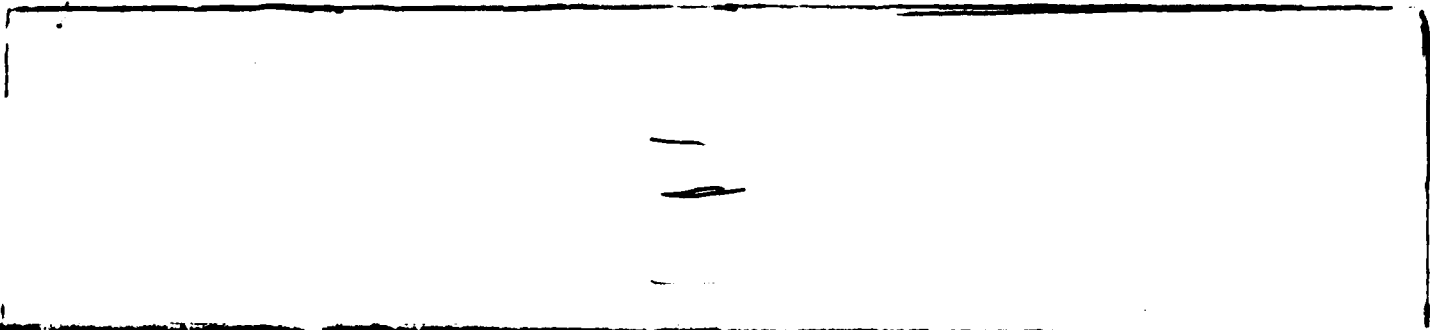


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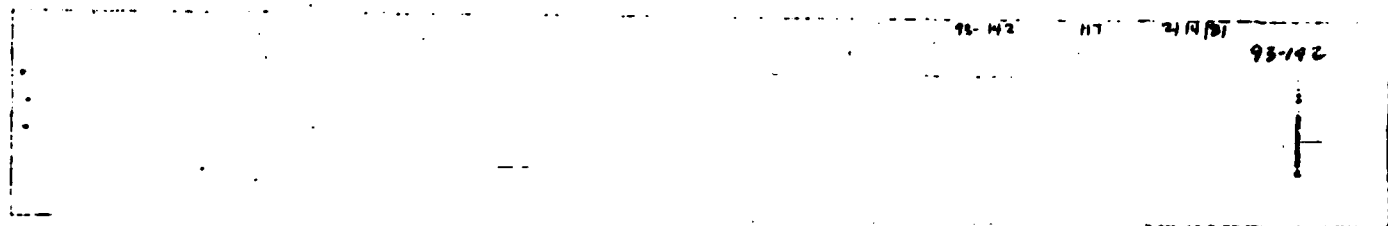
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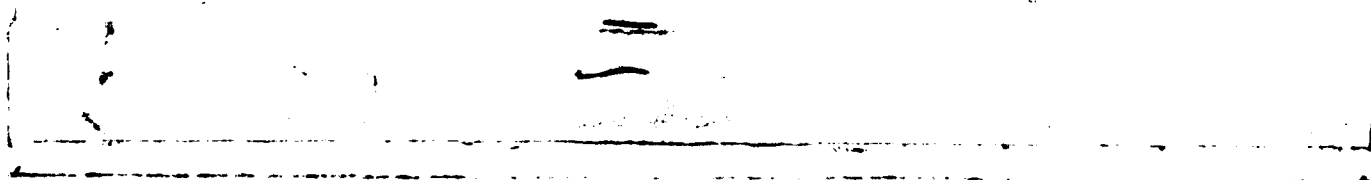
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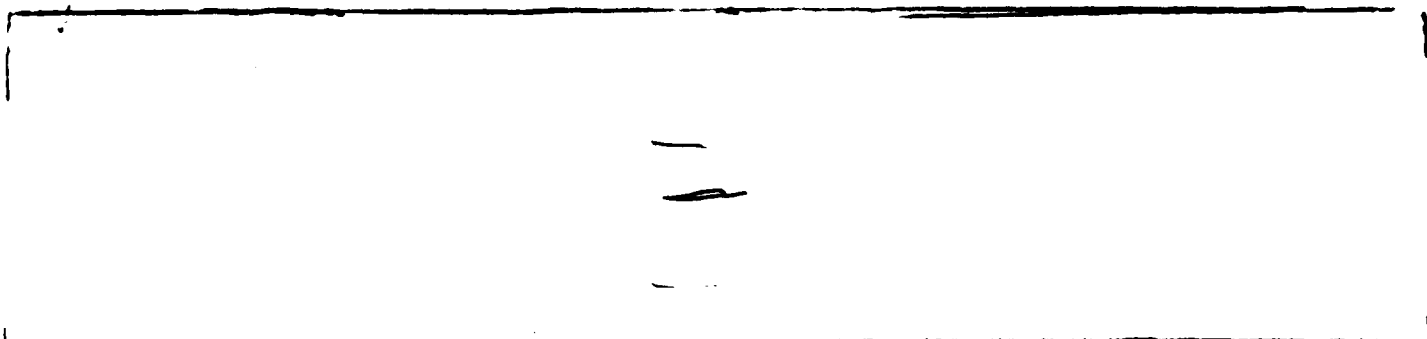
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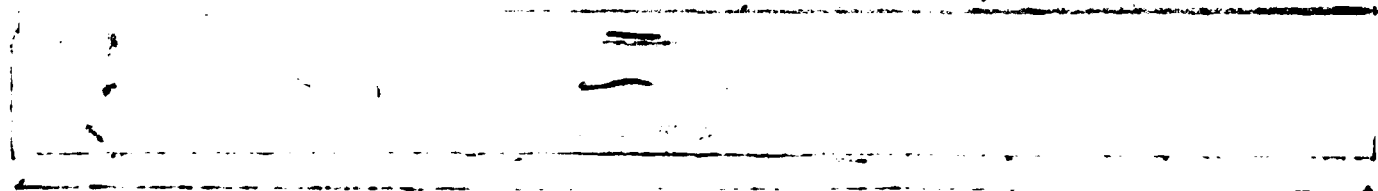




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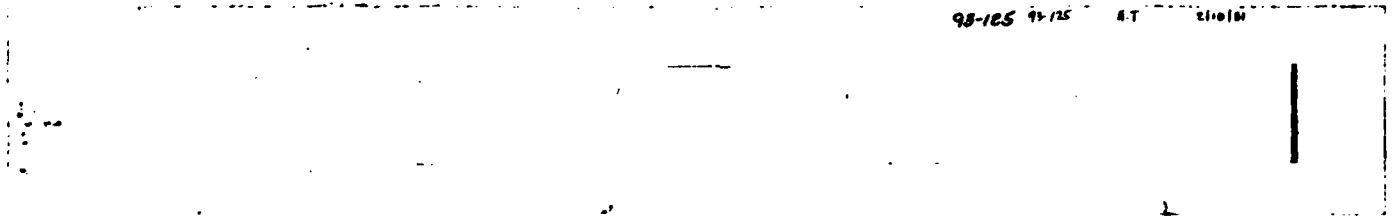
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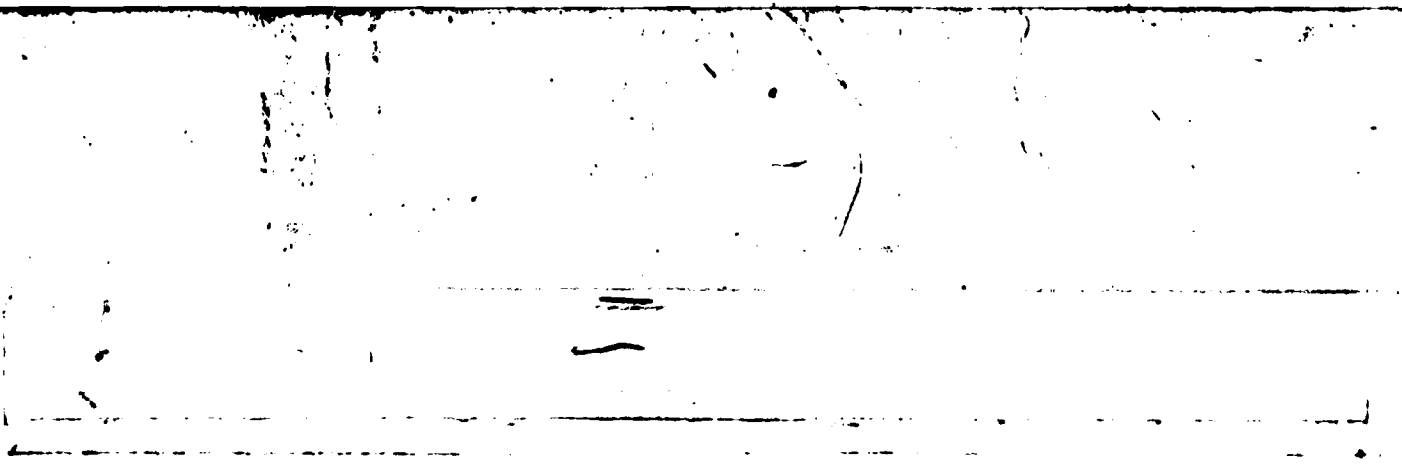
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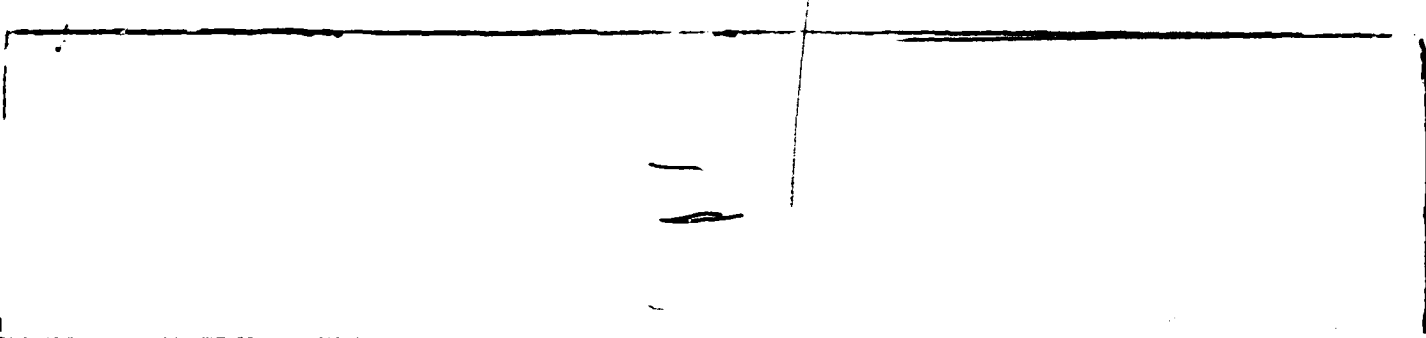


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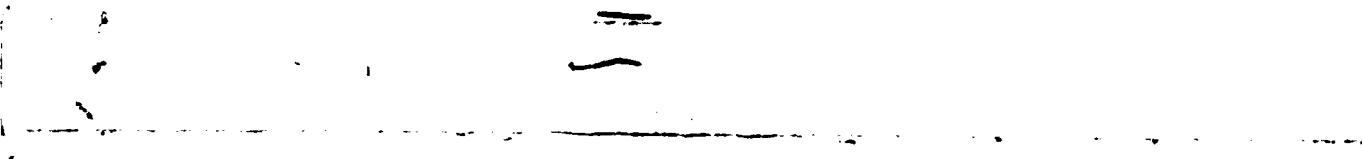
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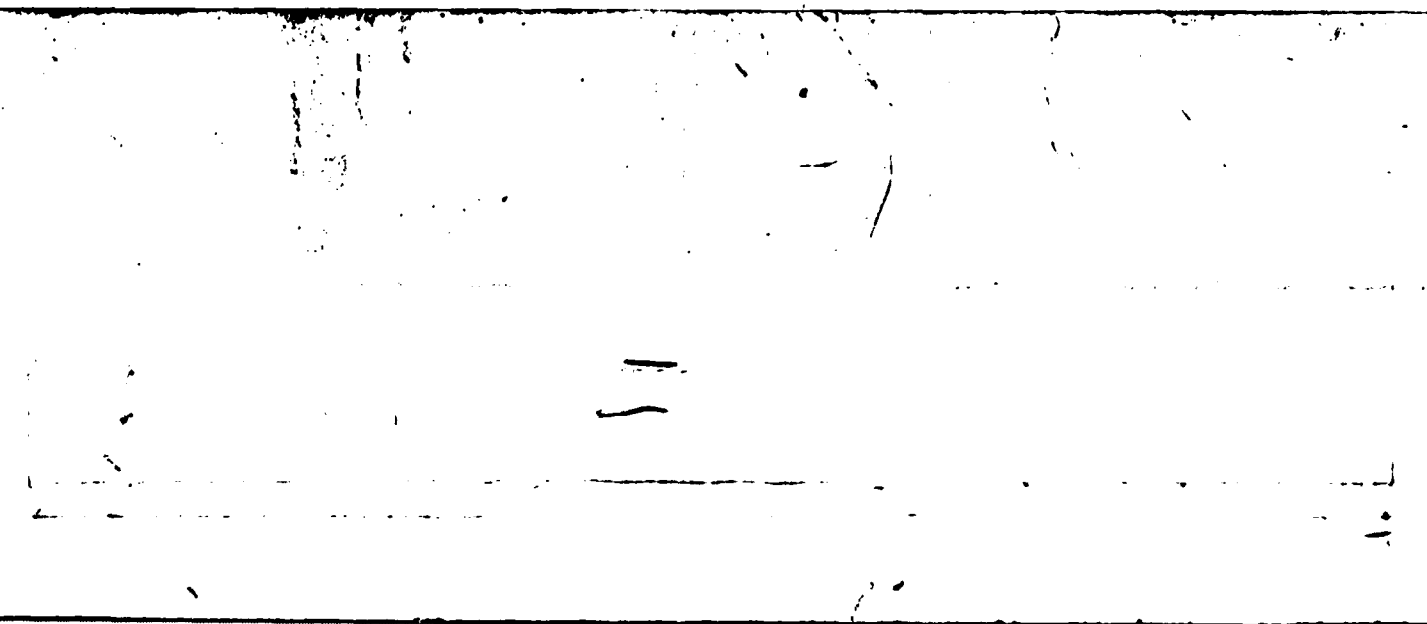
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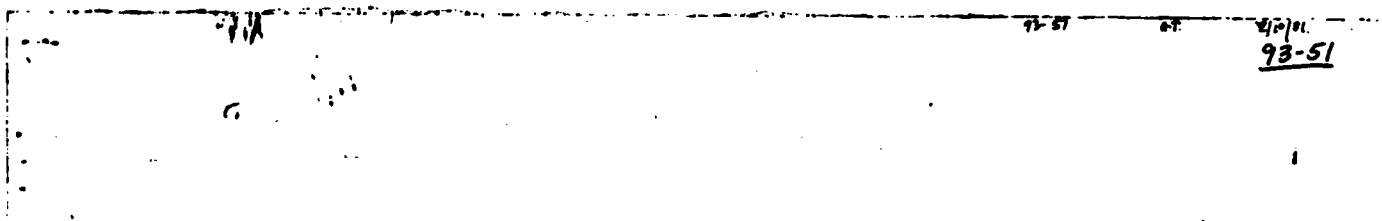
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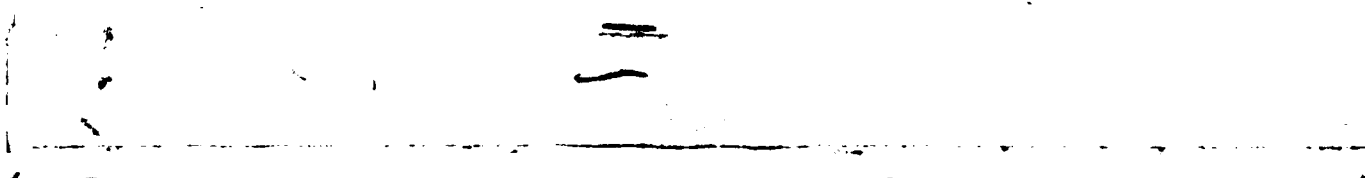
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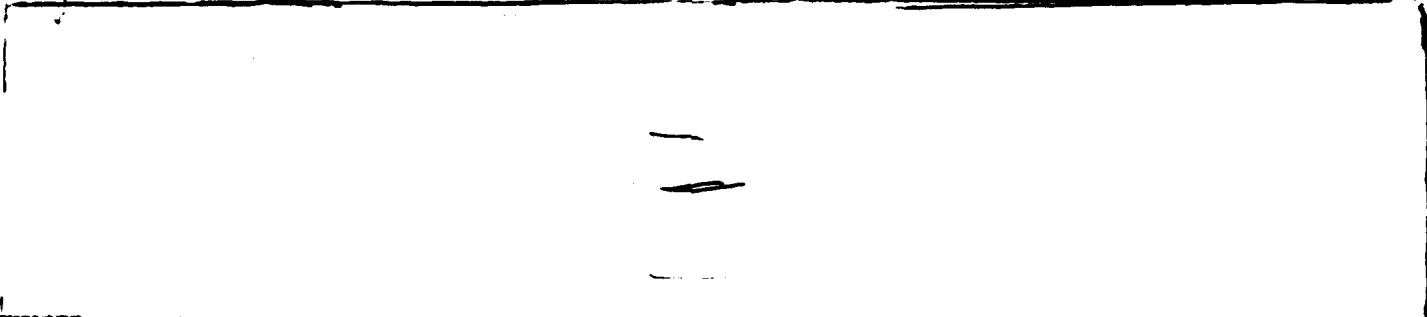


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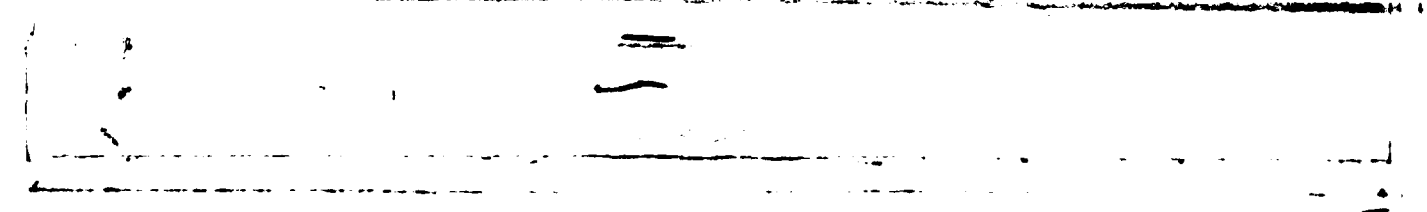




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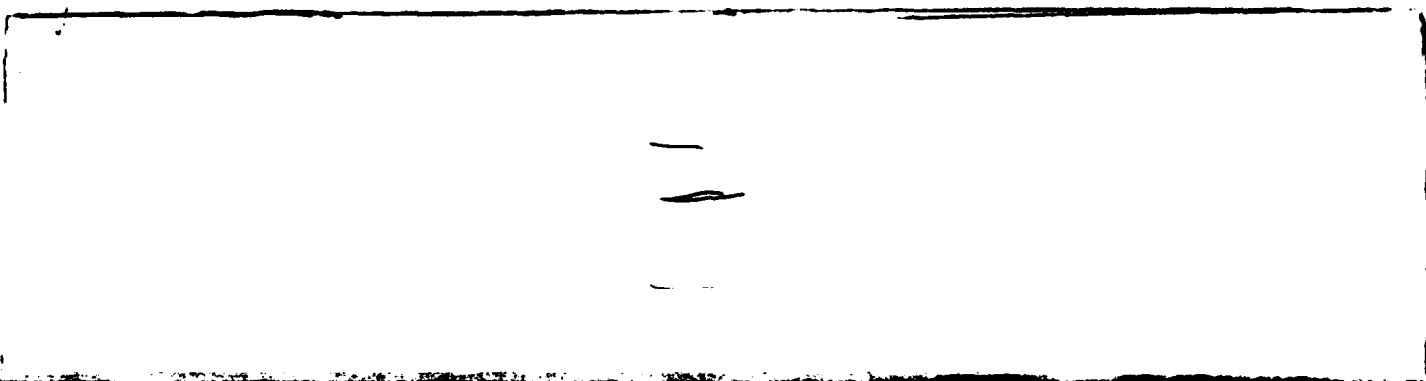
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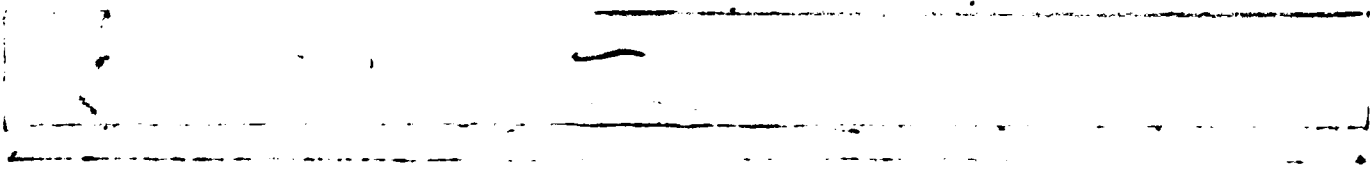
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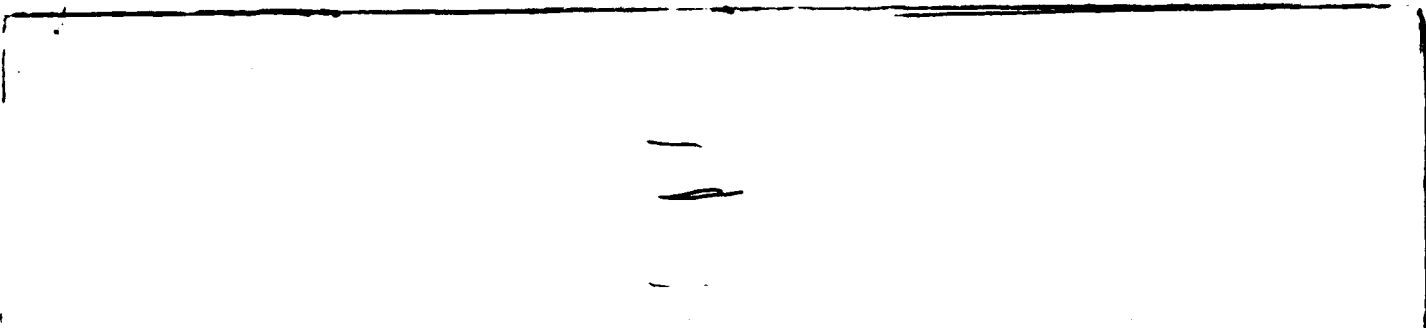


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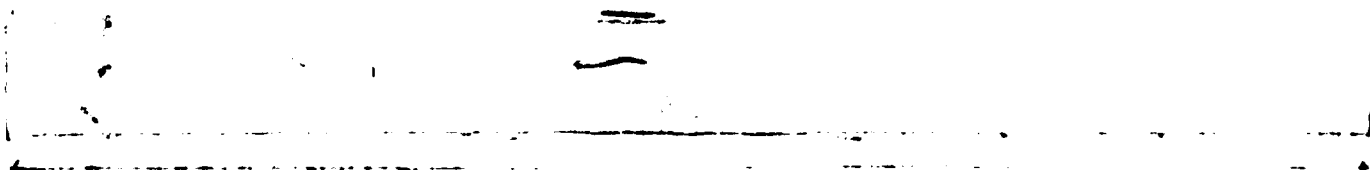
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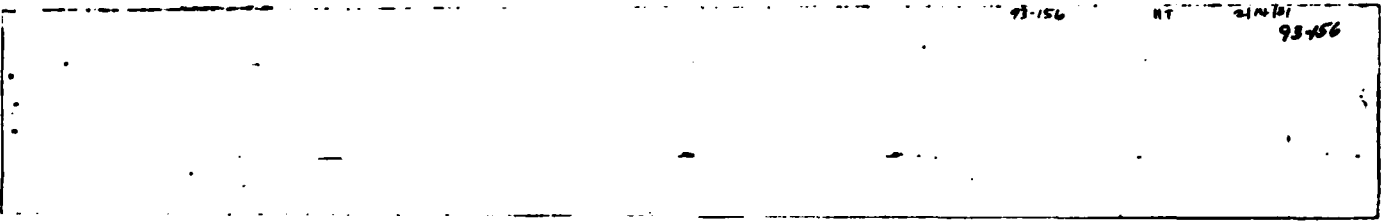
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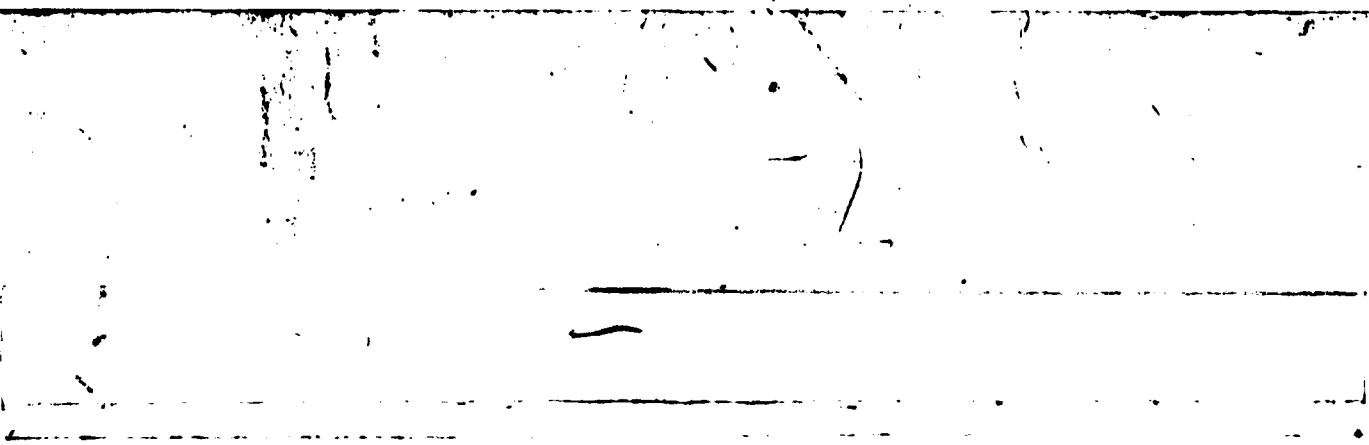


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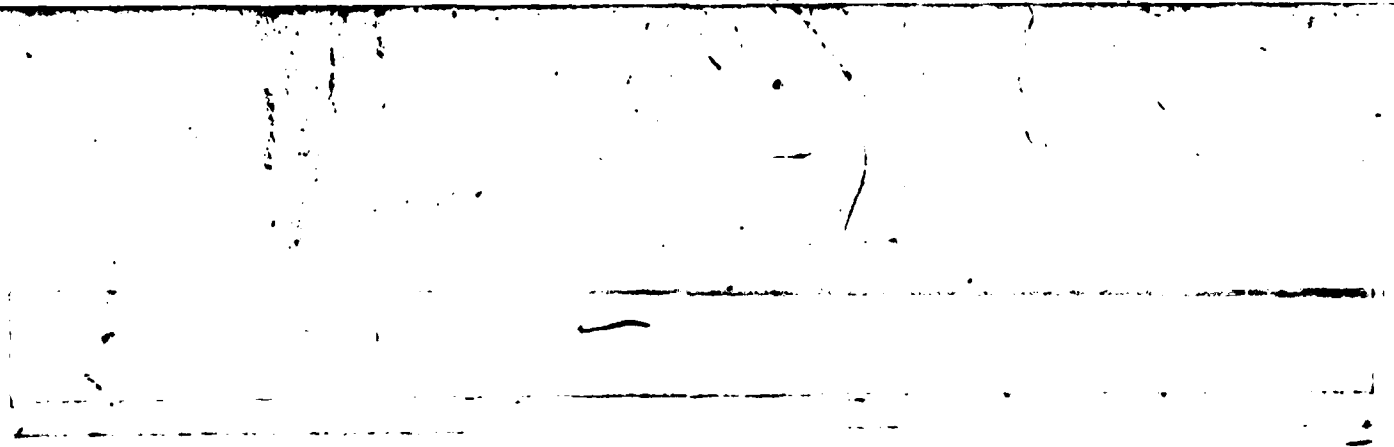
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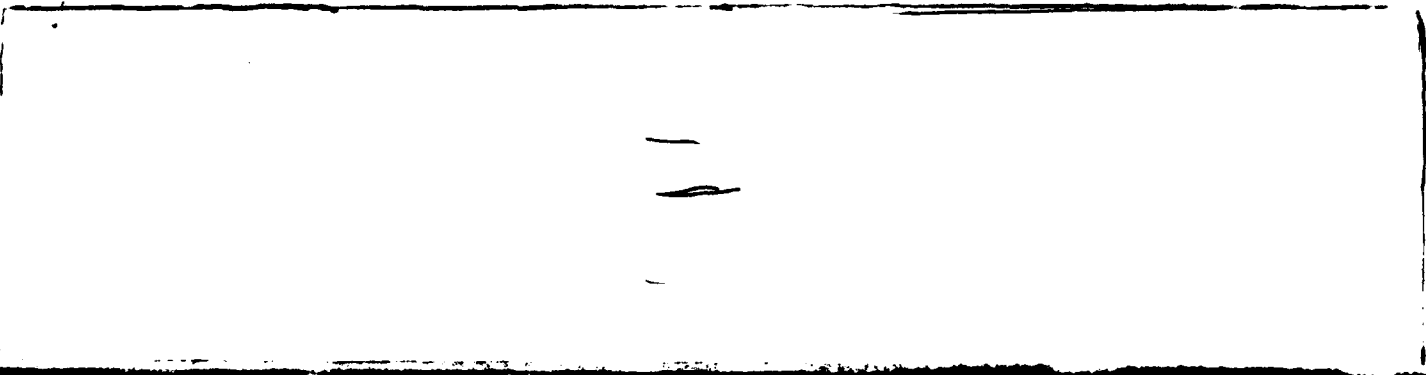
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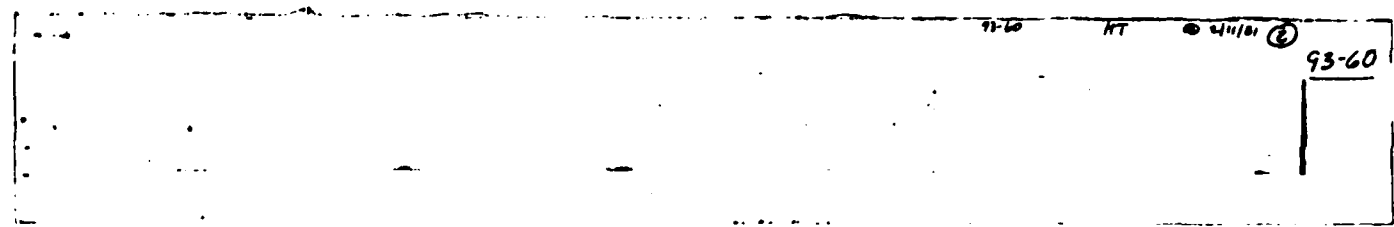


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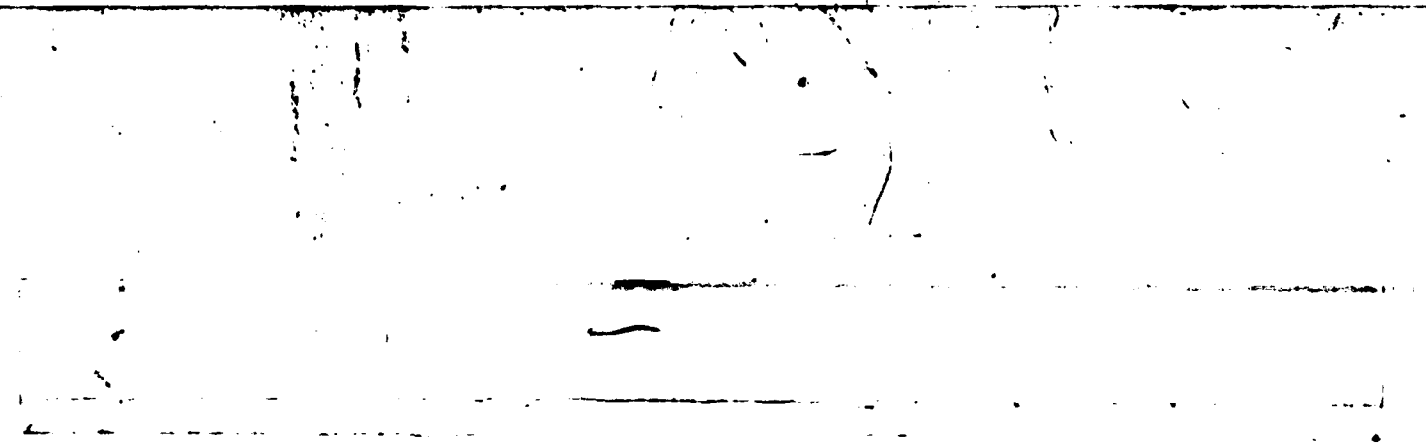
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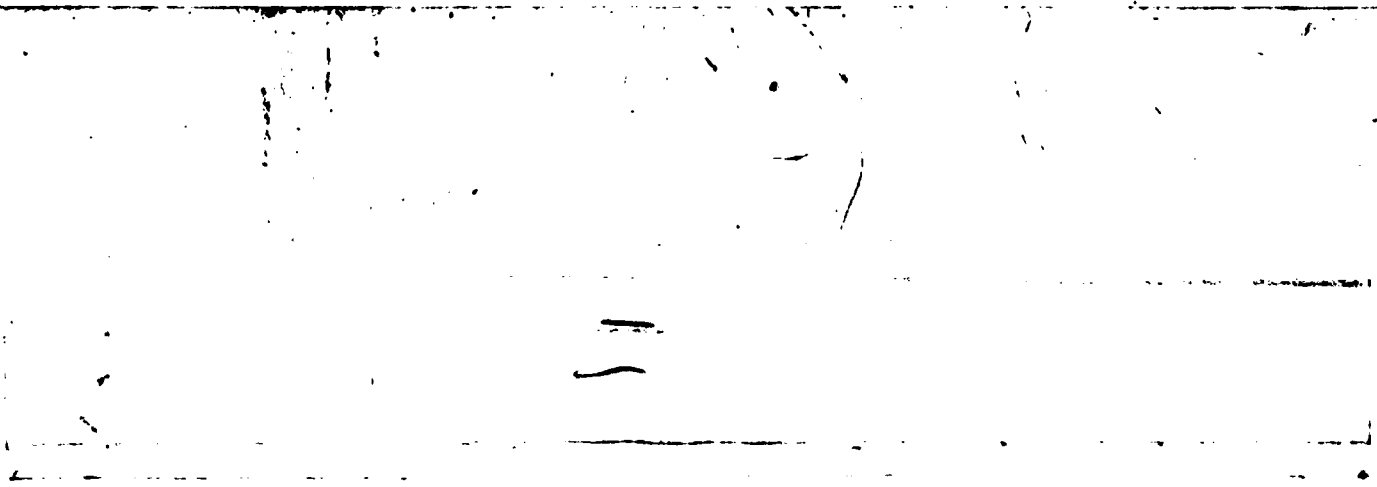
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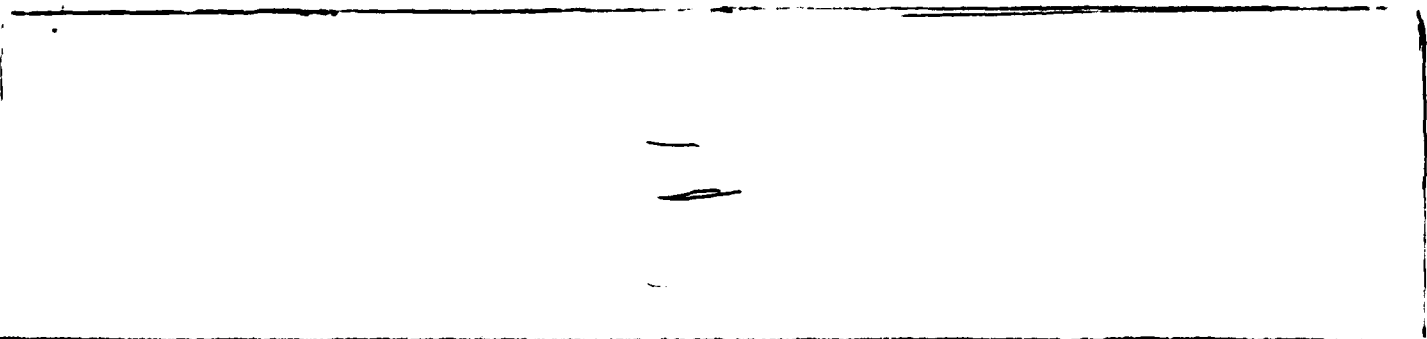


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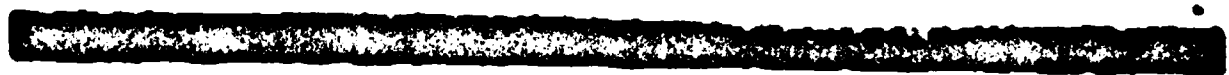
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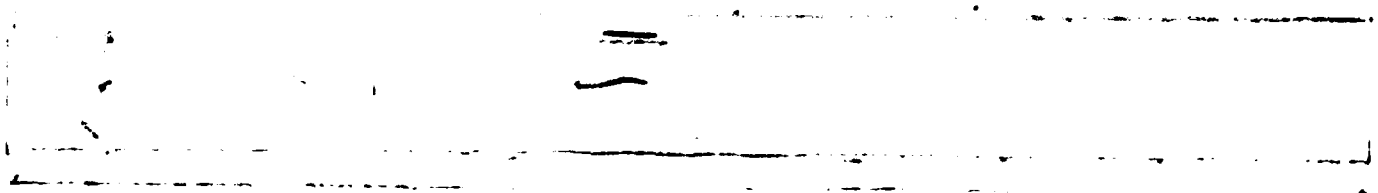
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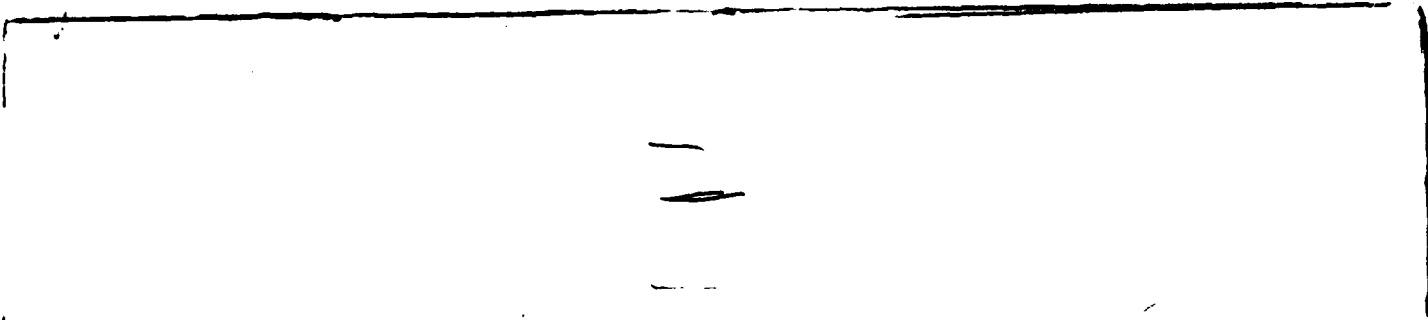
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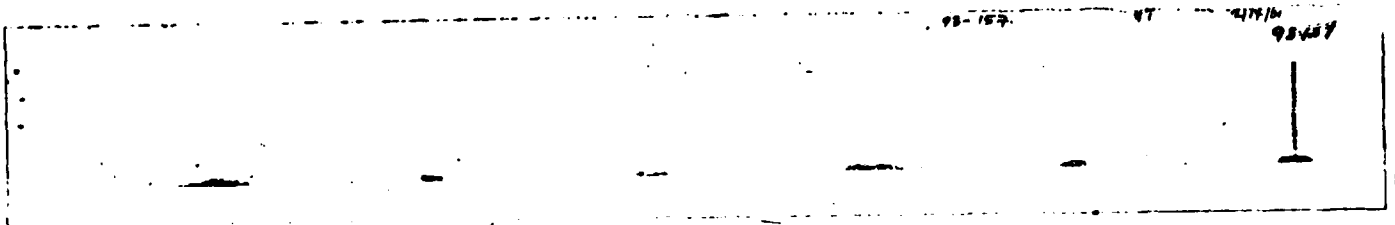


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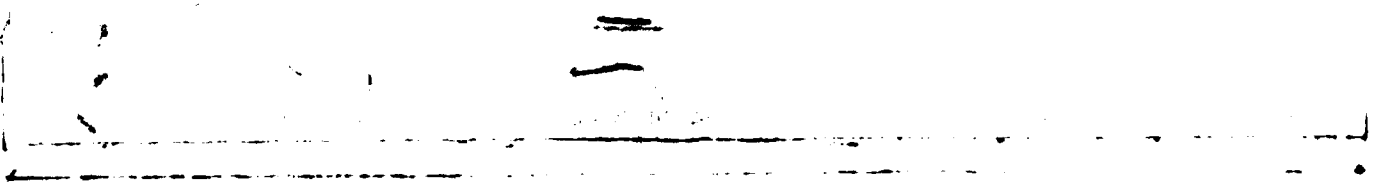


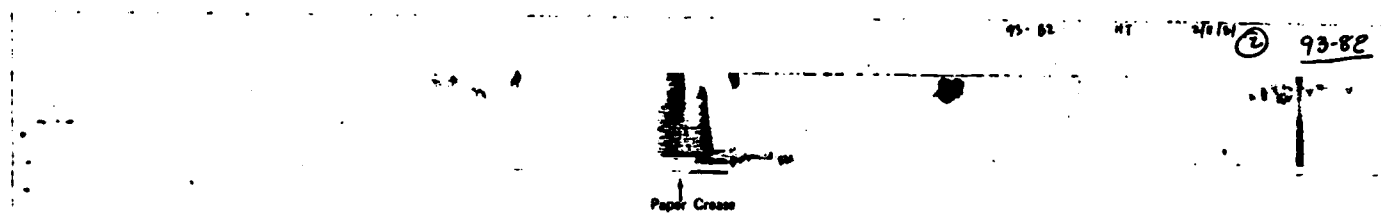


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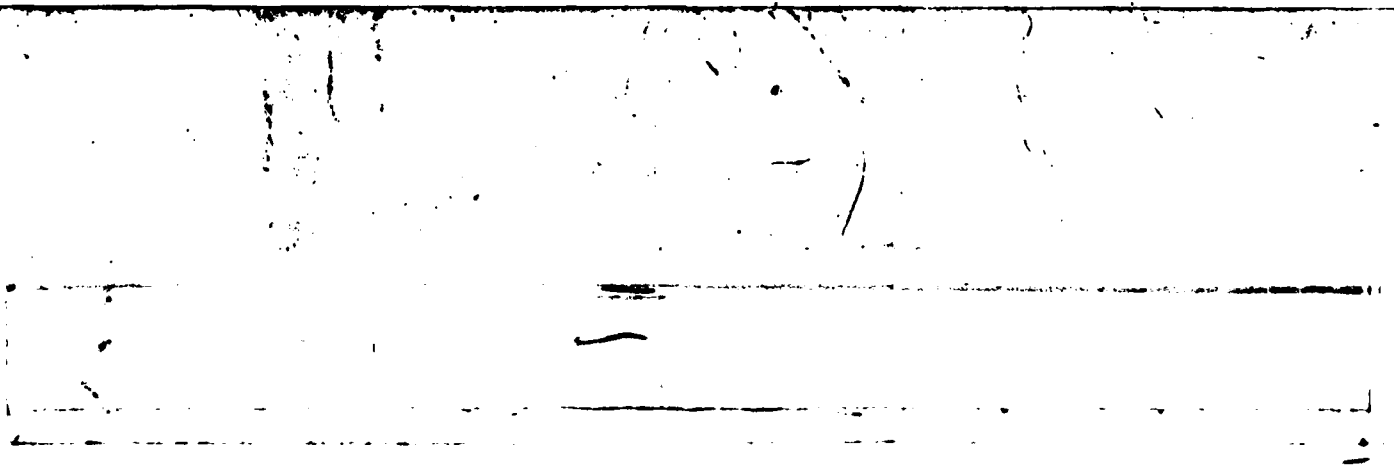
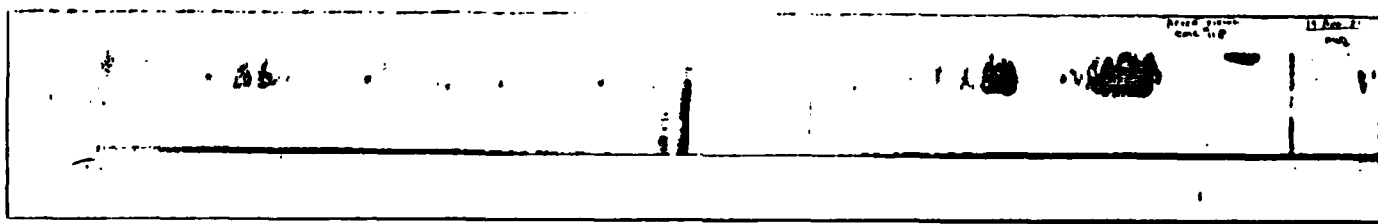
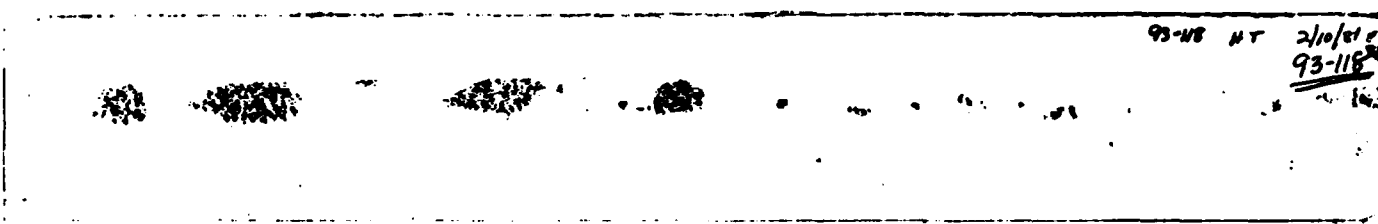
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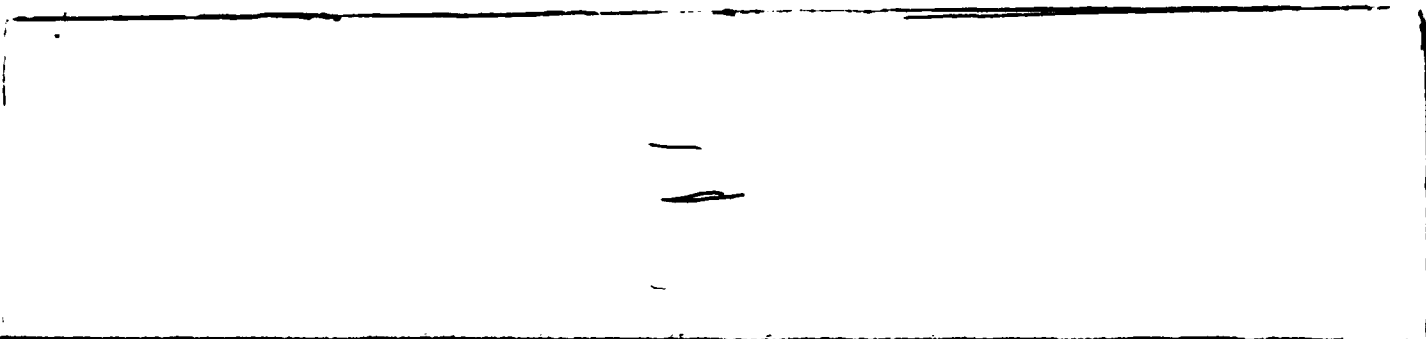
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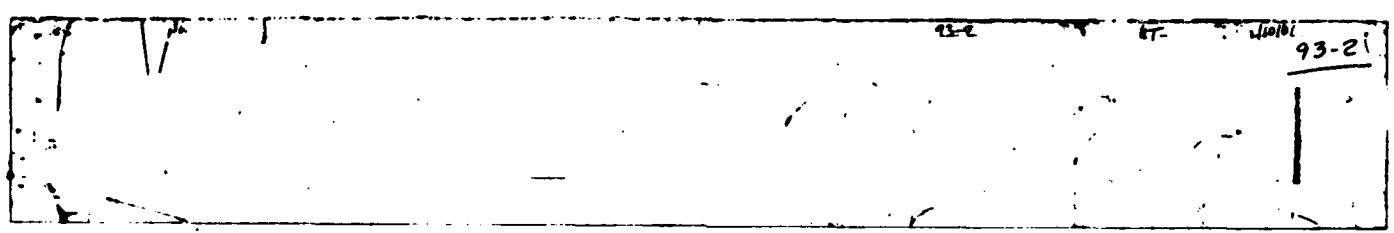
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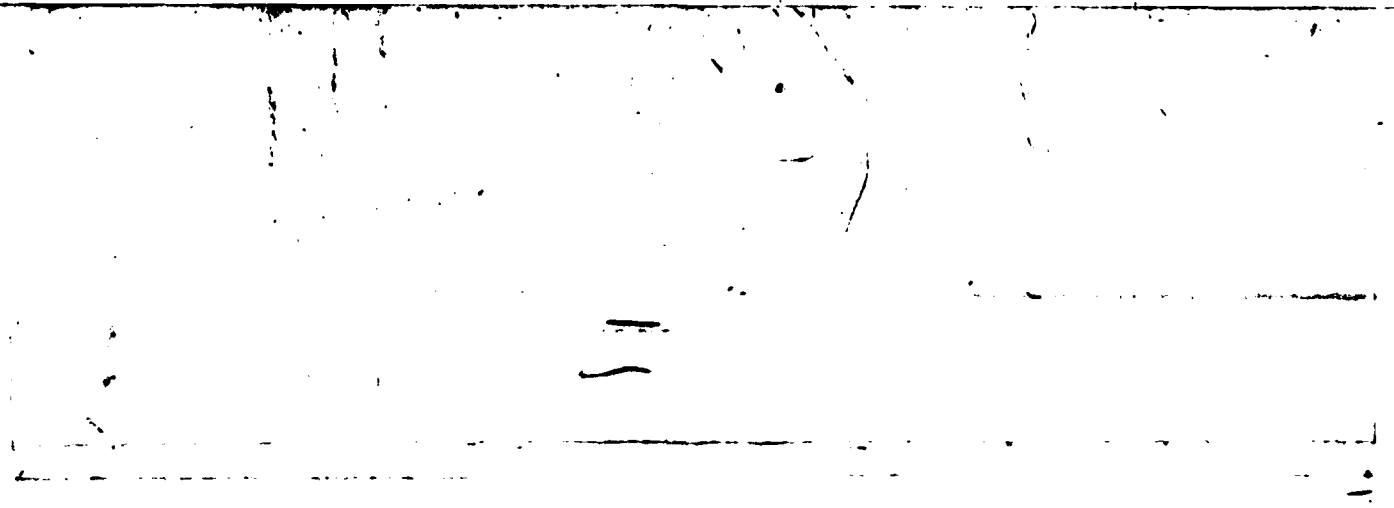
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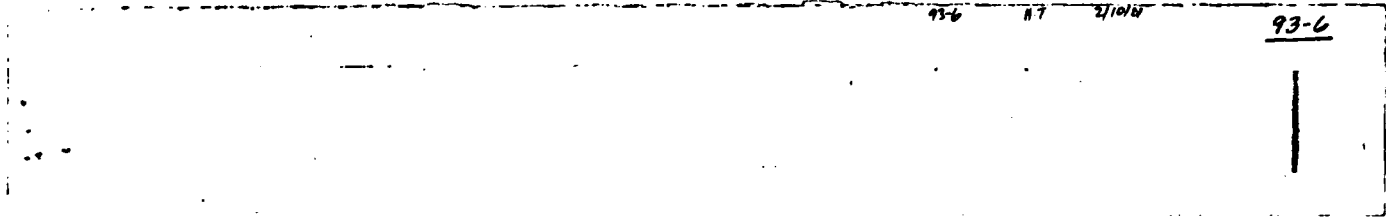
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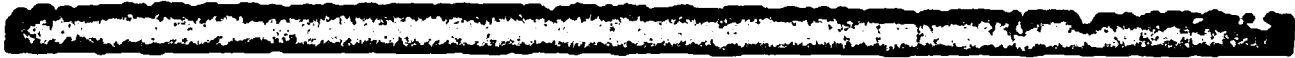
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93-6 H7 2/10/87

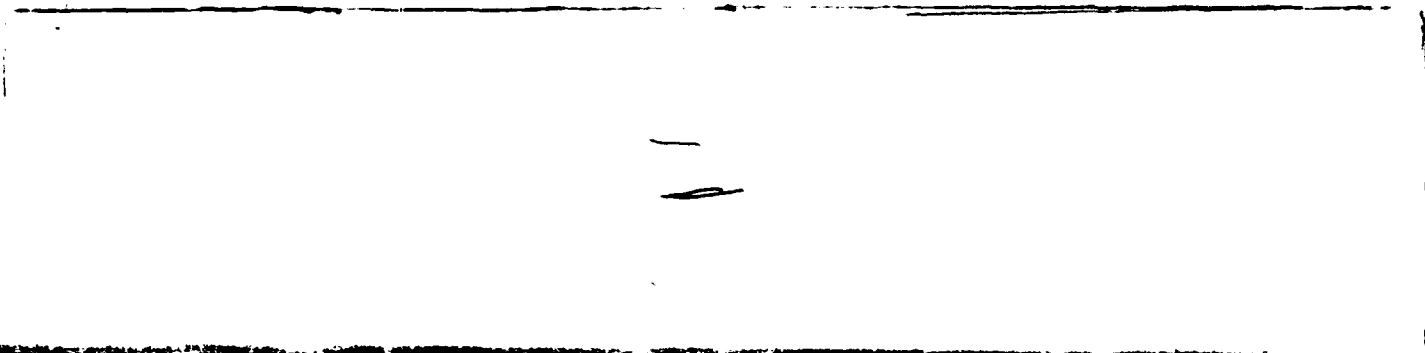
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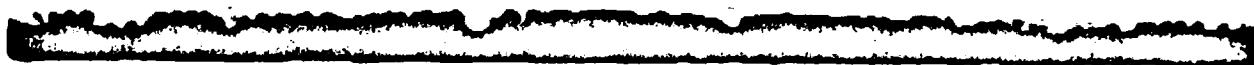
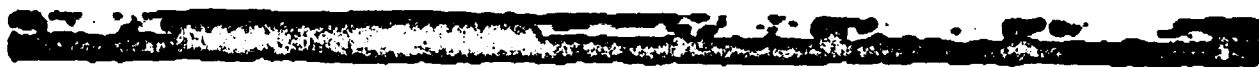


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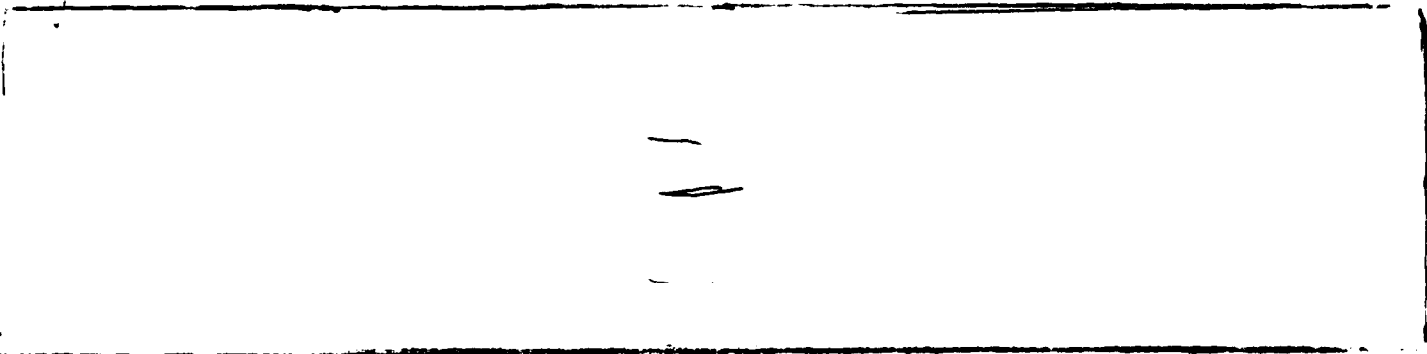
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93-18 8-7 2/14/51

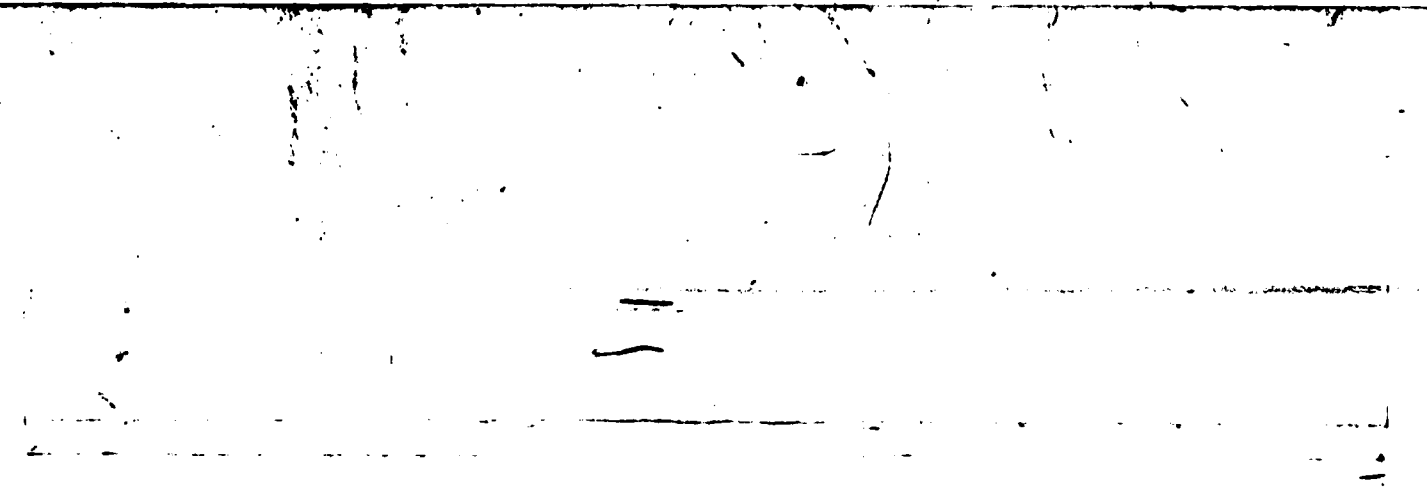
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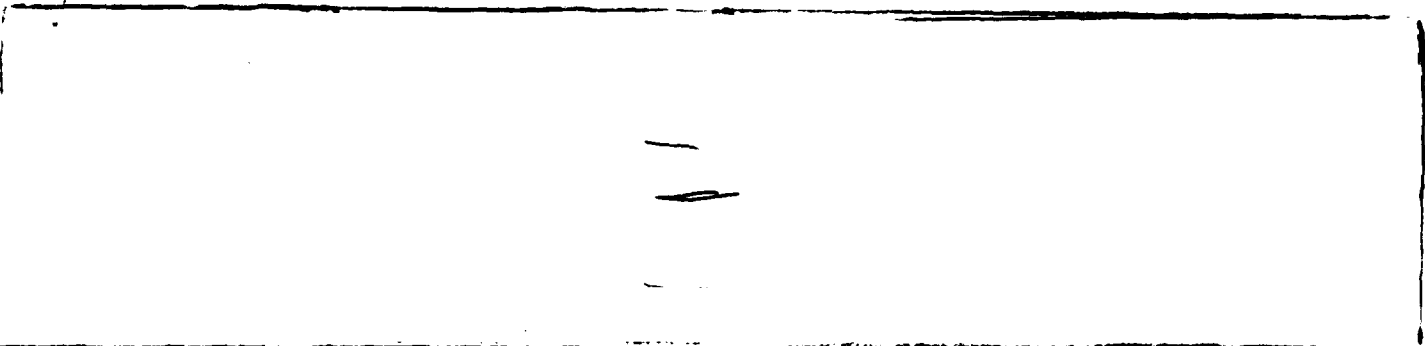
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41-44 47 4/20/91
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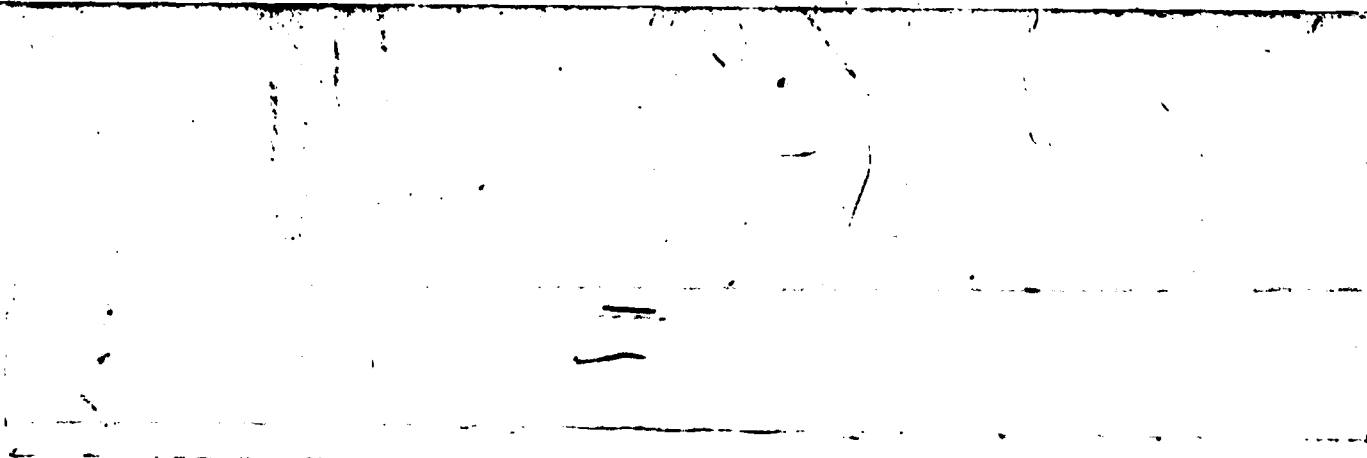
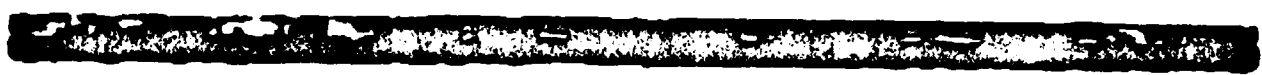
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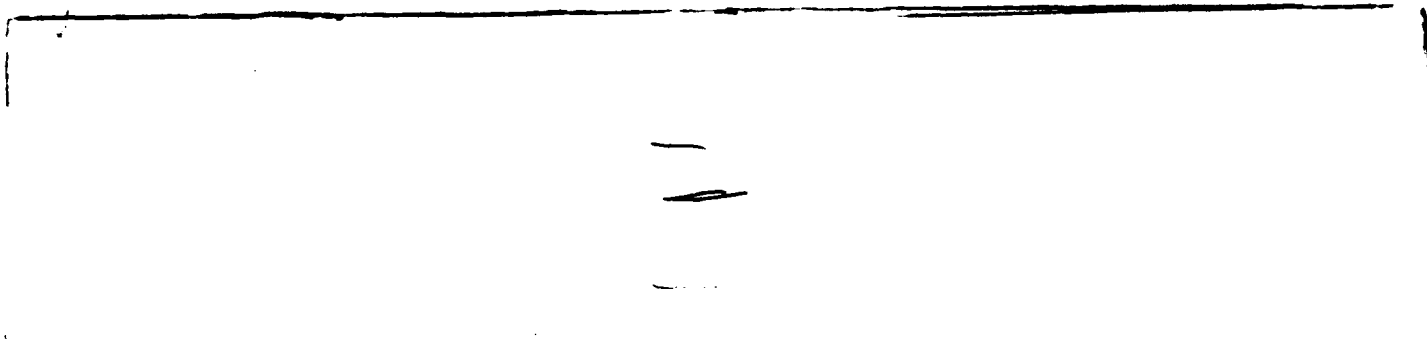




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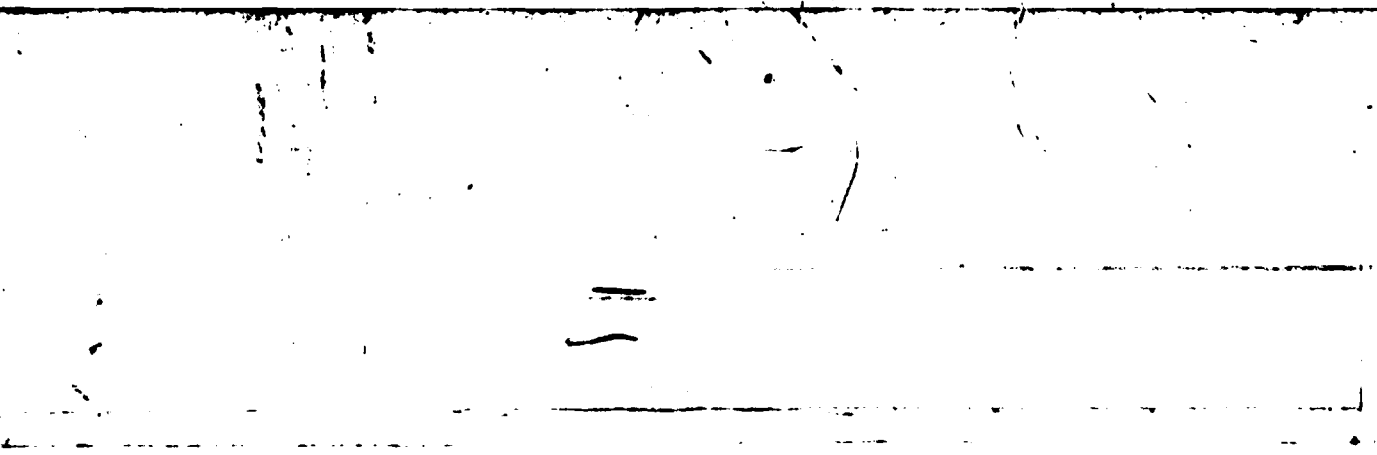
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93-27 97 9/10/14 93-27
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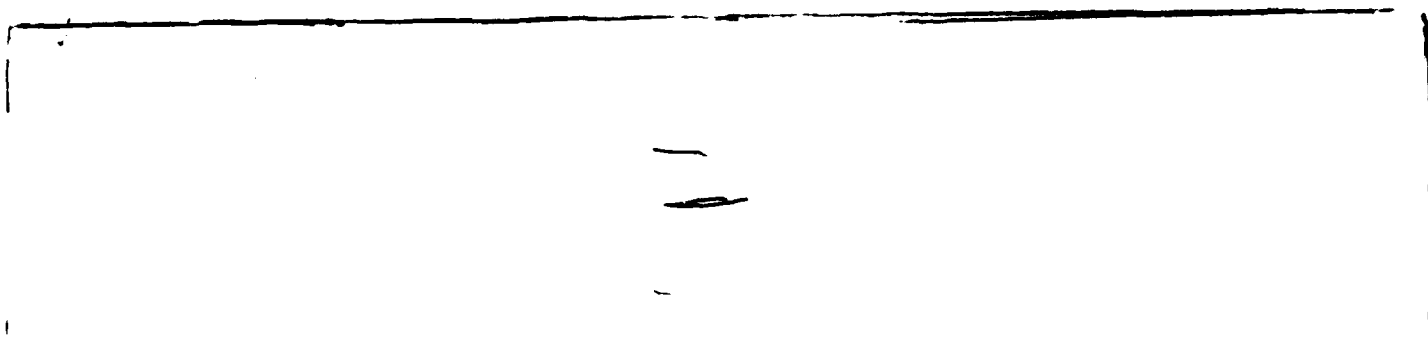


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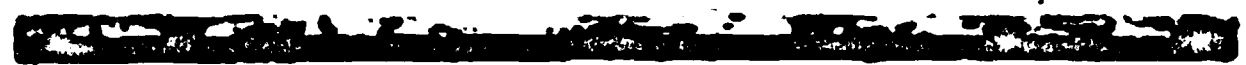


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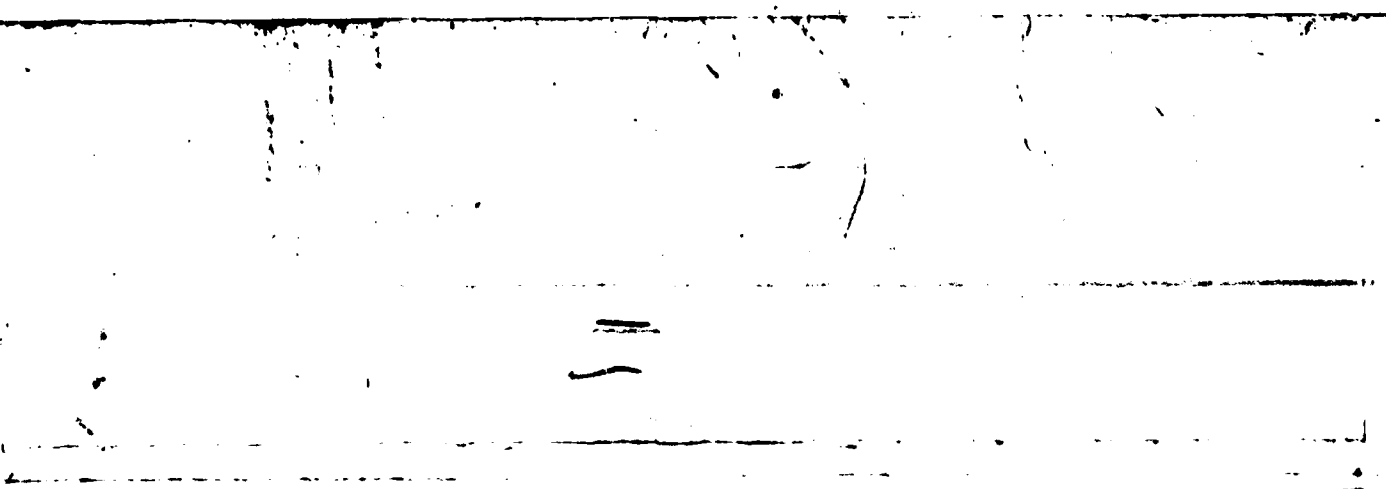
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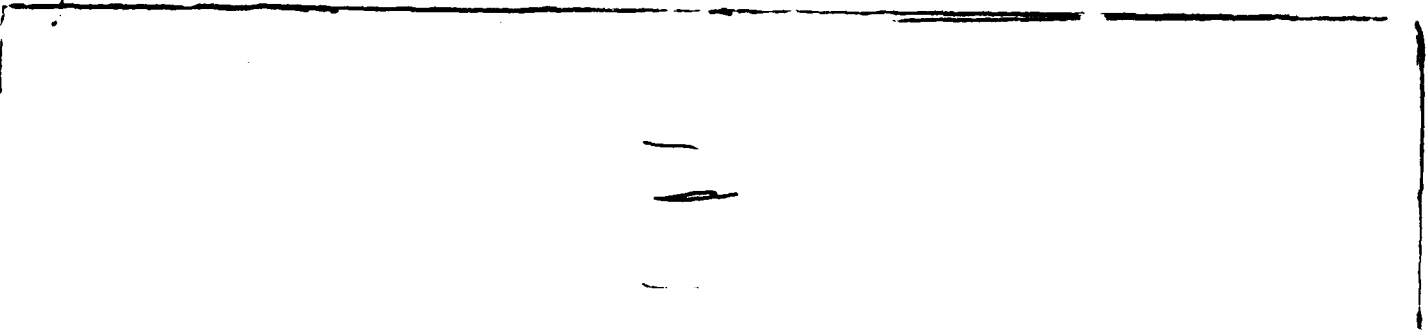
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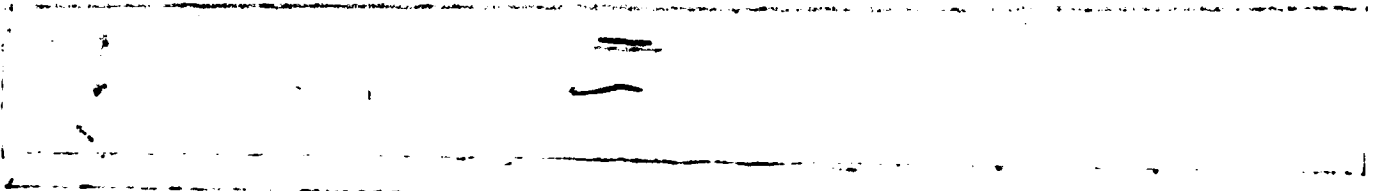
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• Paper Cross

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75-61 A.T. 2/10/91
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• Paper Crosses

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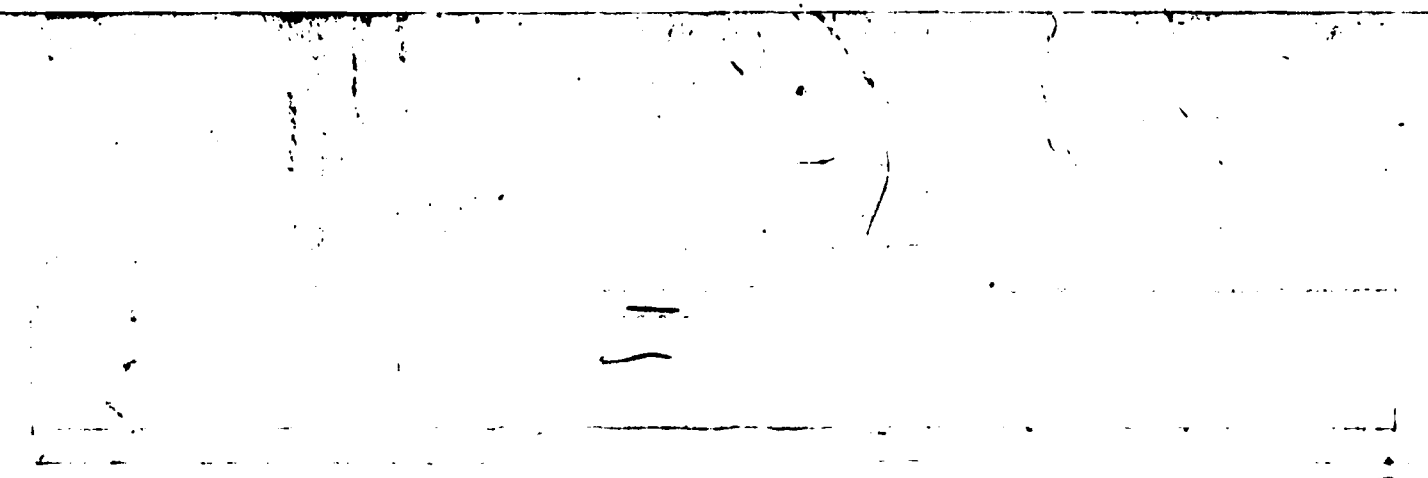
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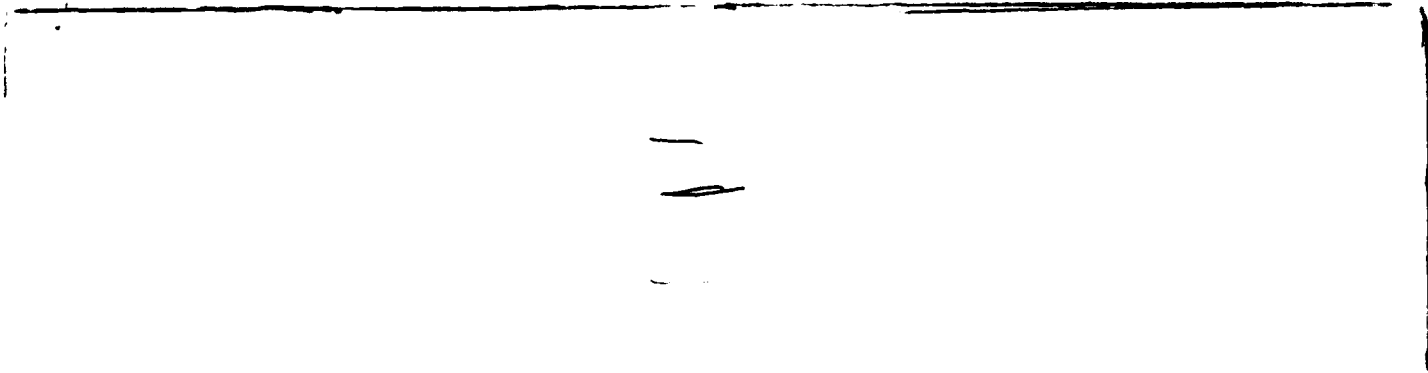
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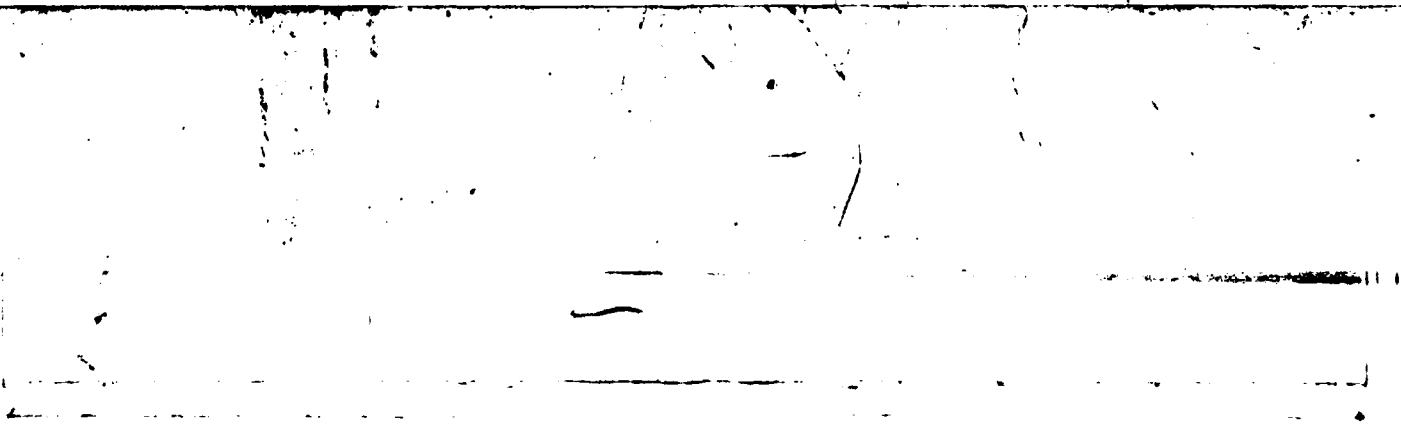
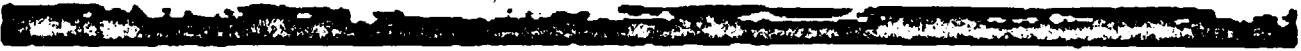


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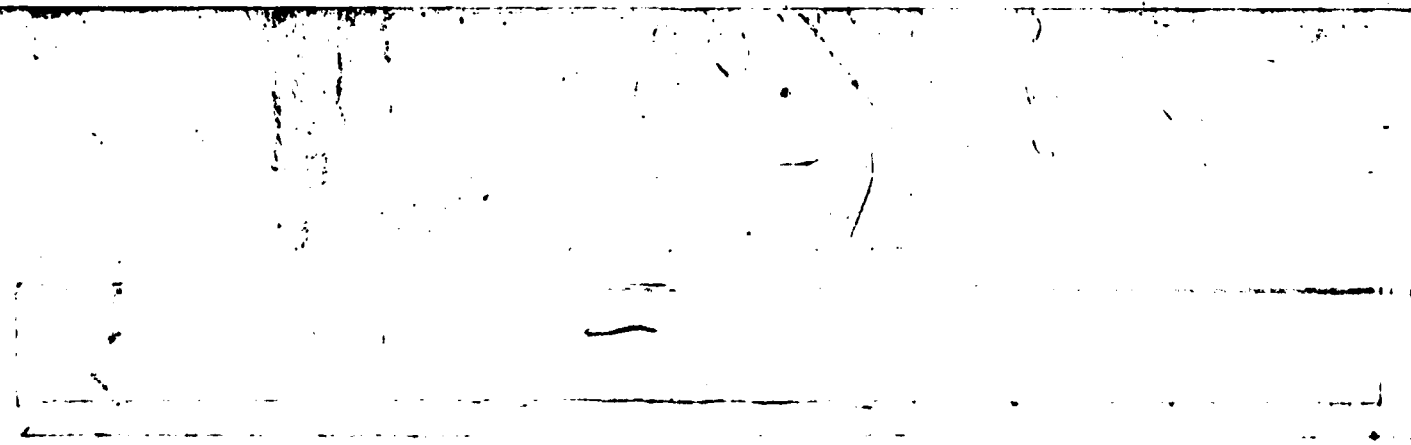


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PROCESS PARAMETERS FOR BANDING 158-MM M483A1
PROJECTILES IN HIGH-CAPACITY... (U) CHAMBERLAIN MFG CORP
WATERLOO IA RESEARCH AND DEVELOPMENT DIV... SEP 82
CB184-PR-072-APP-B ARLCD-CR-82028-APP-B F/G 19/1

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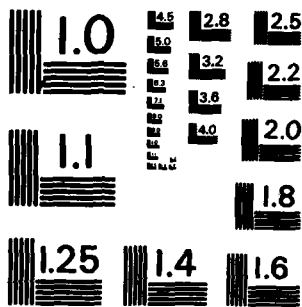
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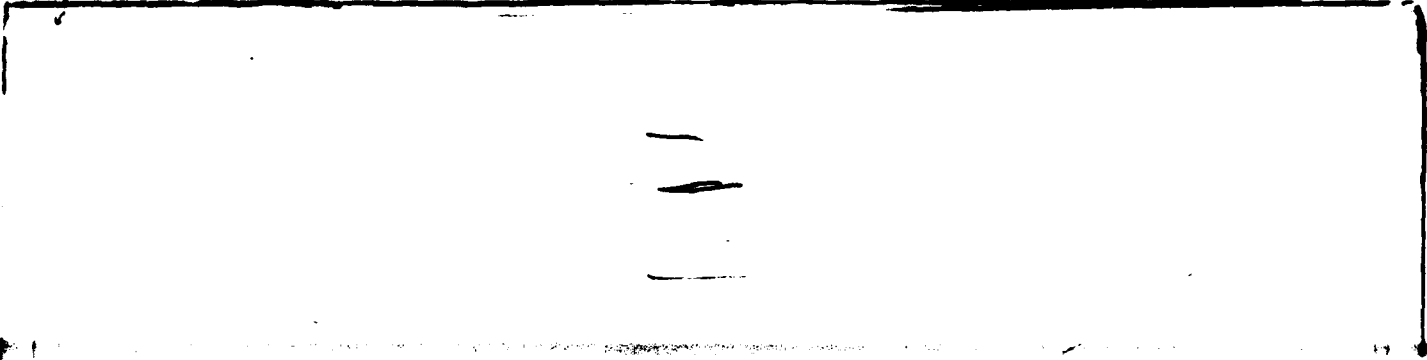
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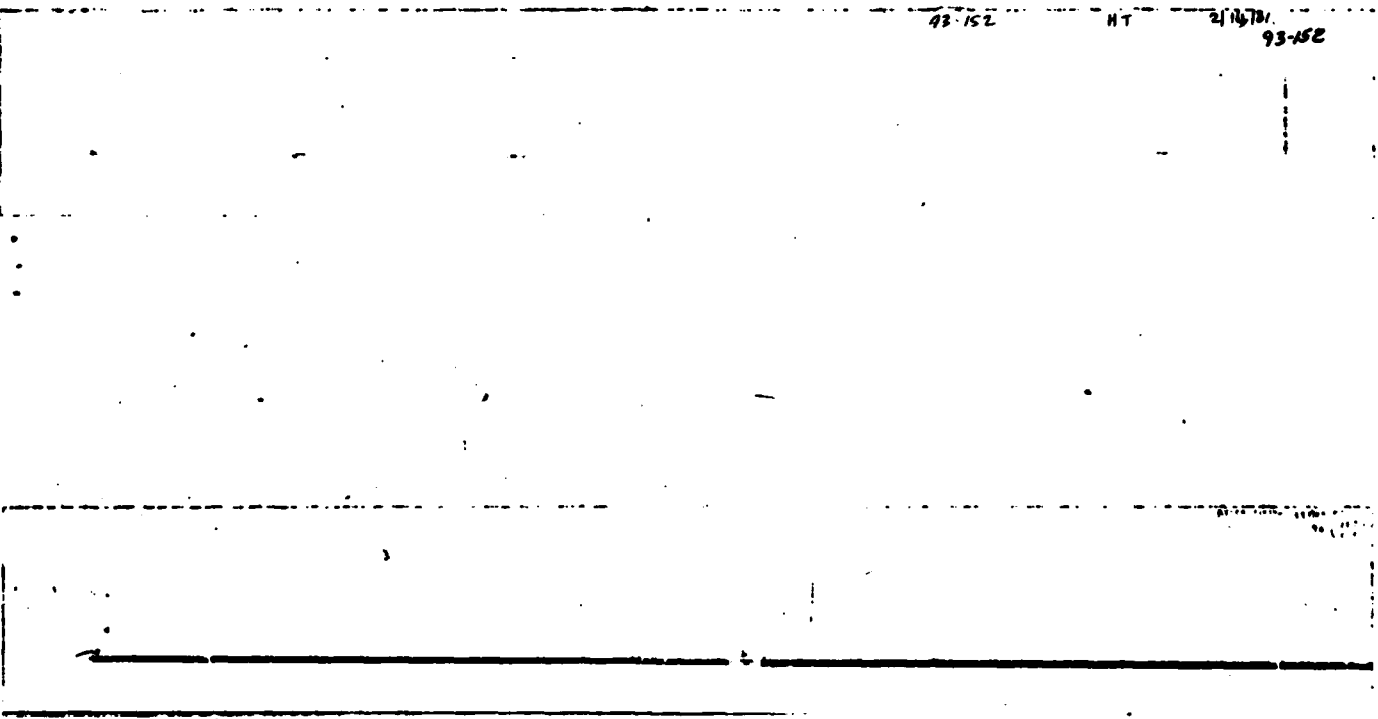
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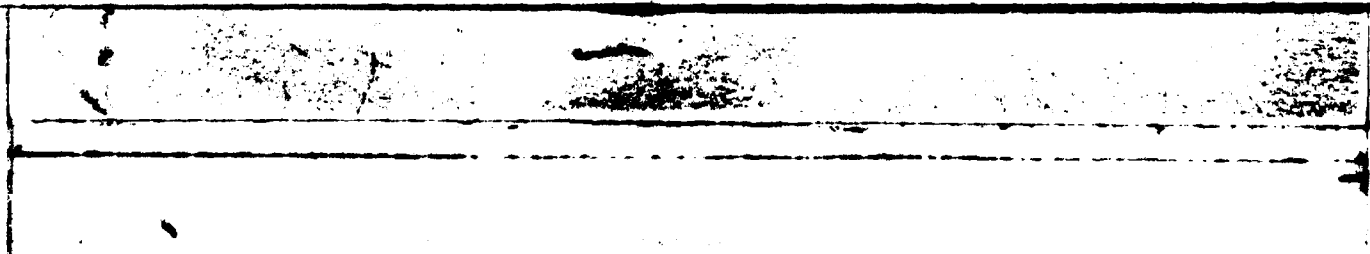
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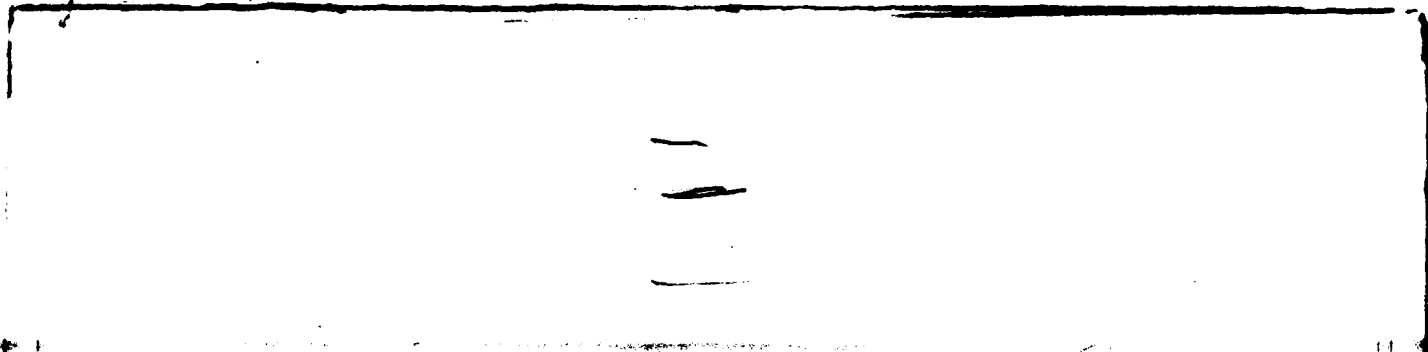
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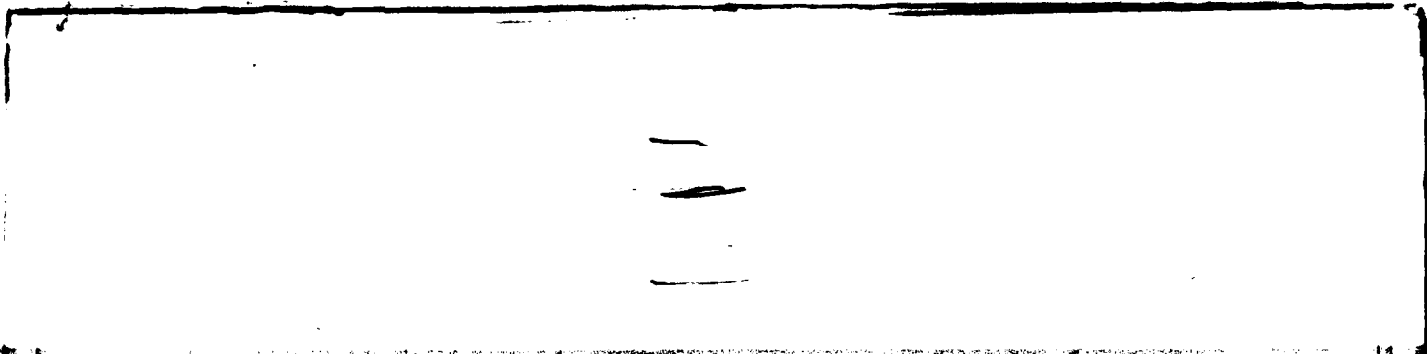
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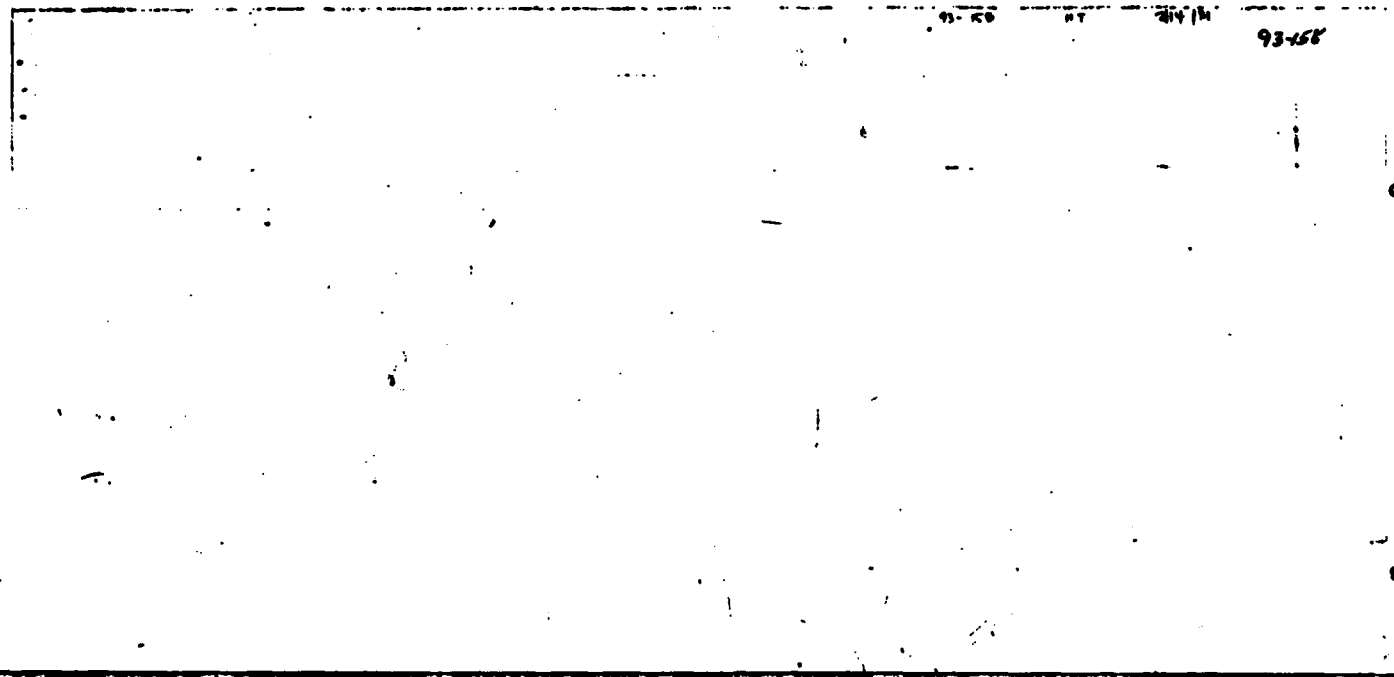
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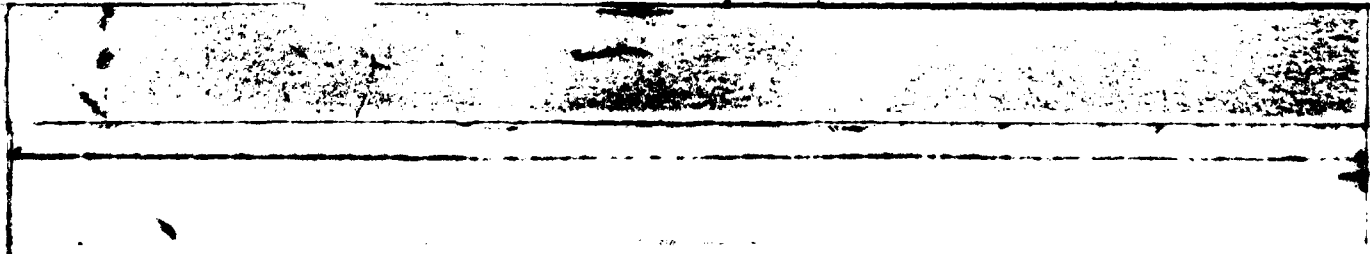


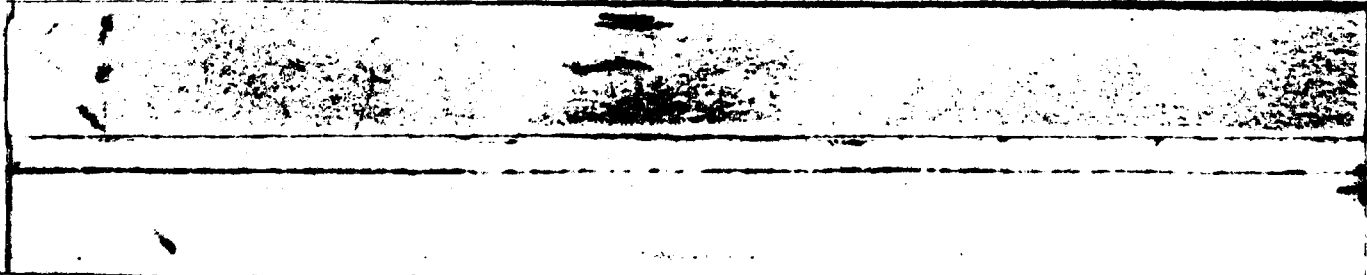
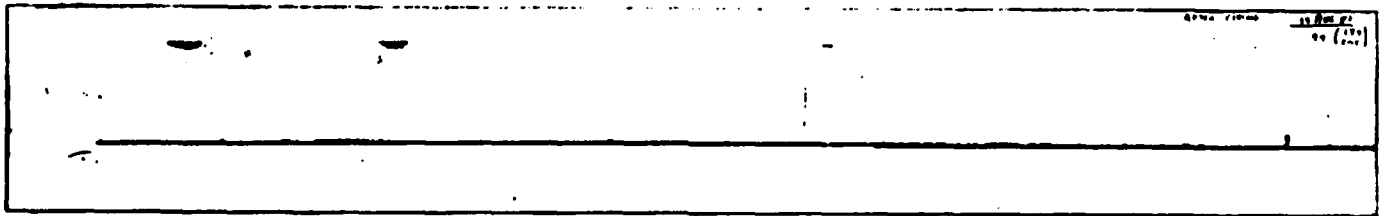
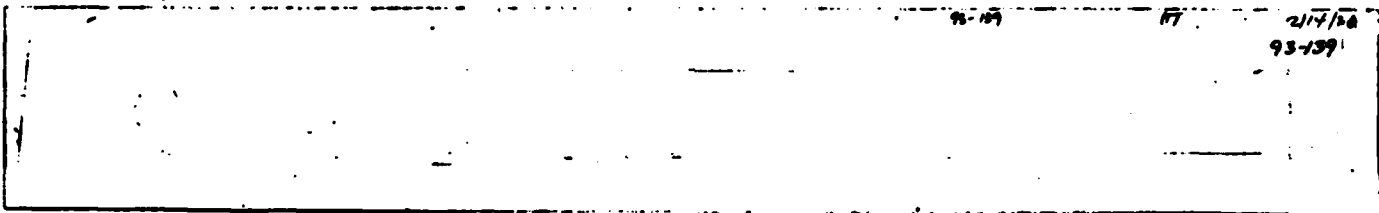
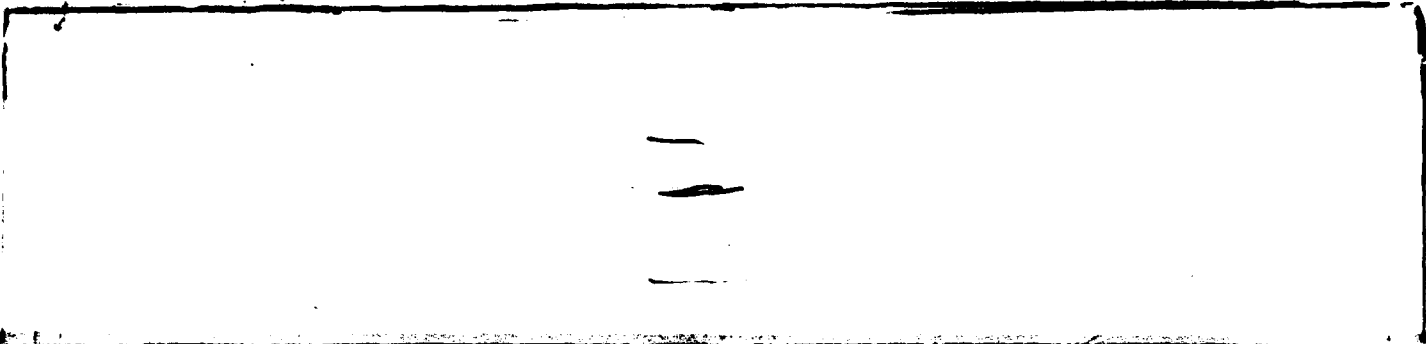
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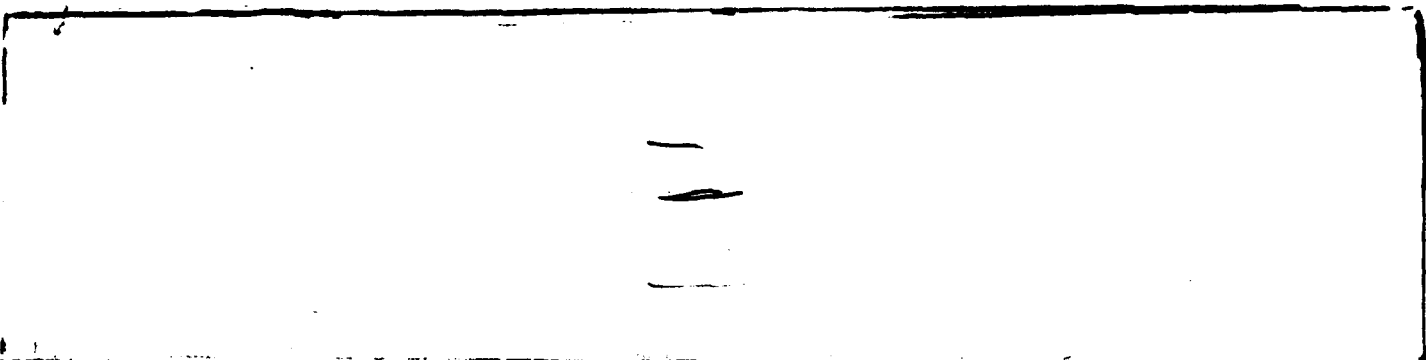


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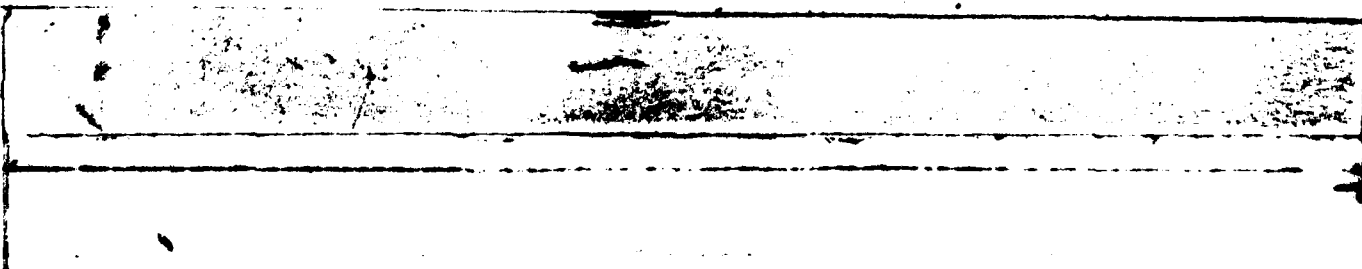
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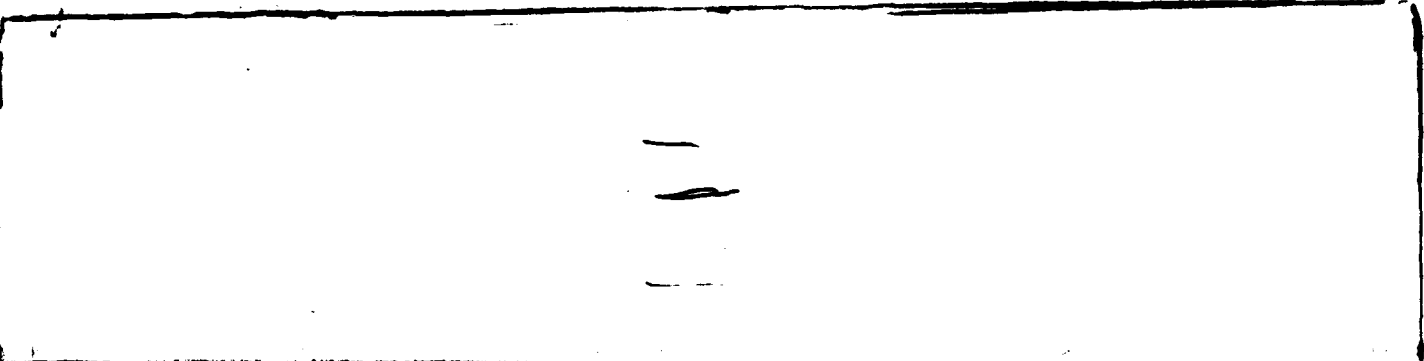
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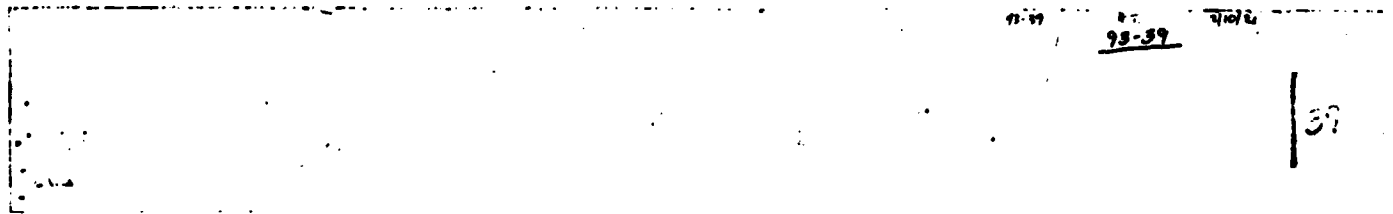
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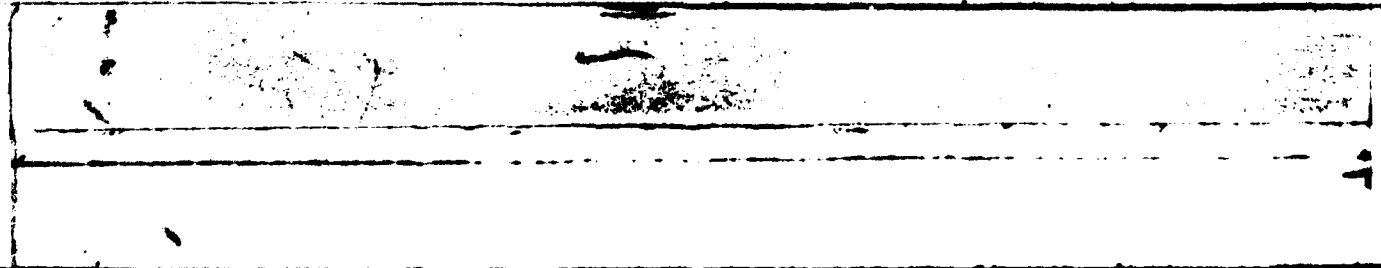
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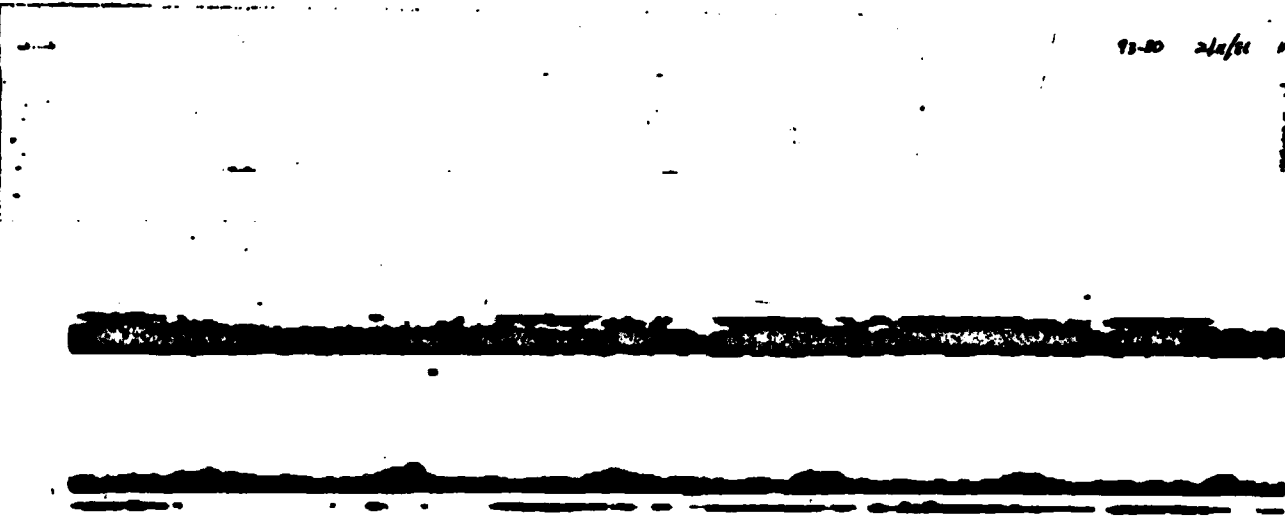


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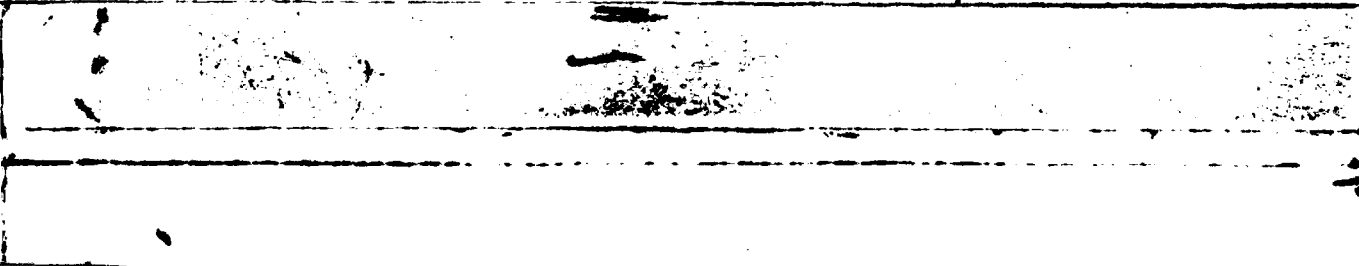
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93-80 2/1/81 # ③
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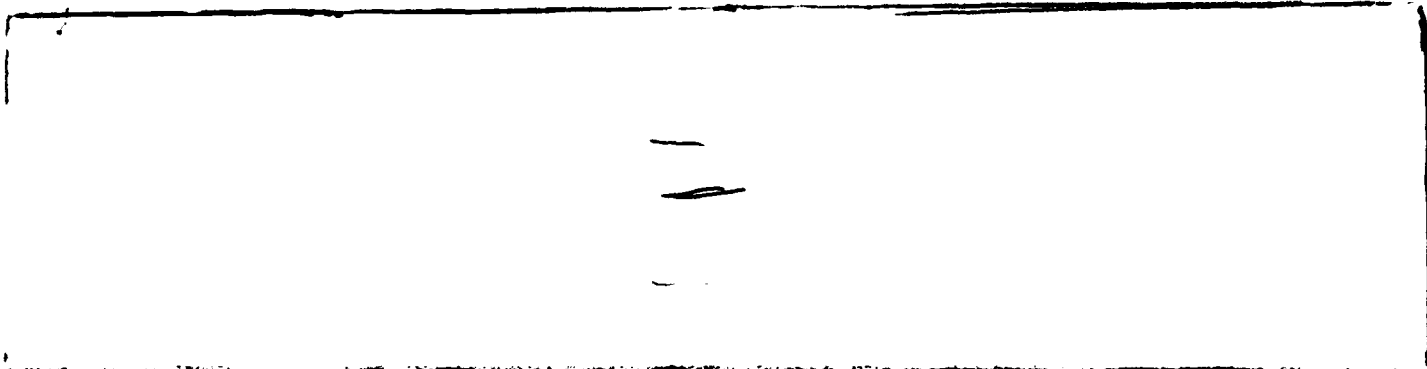
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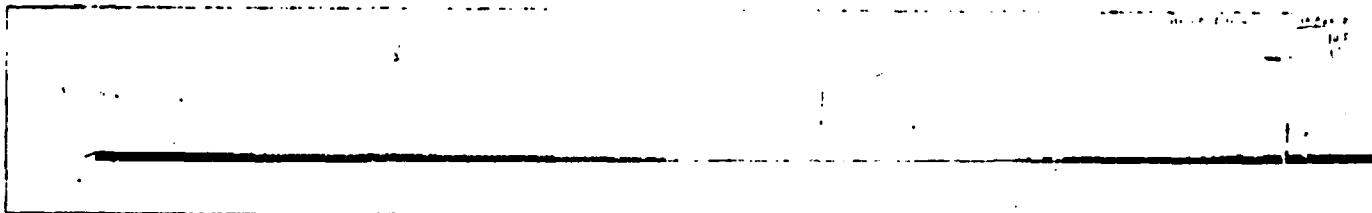
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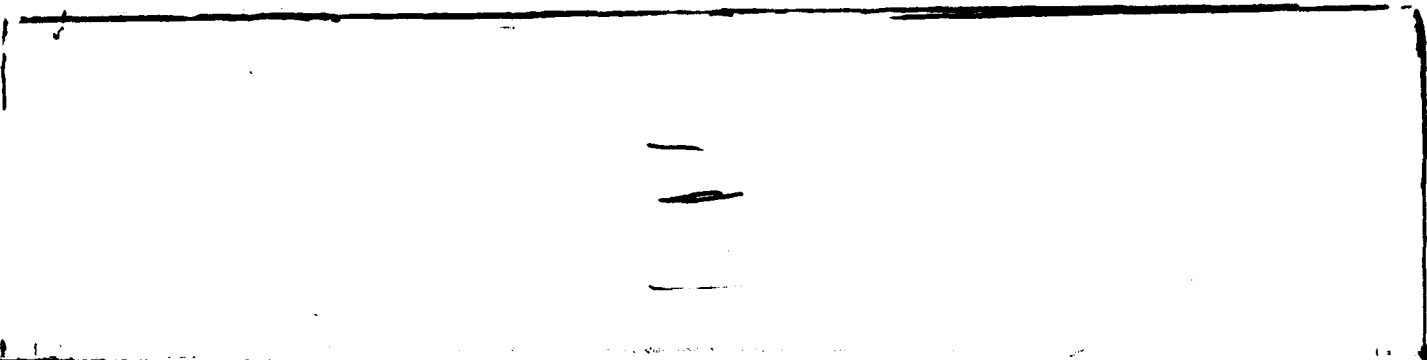
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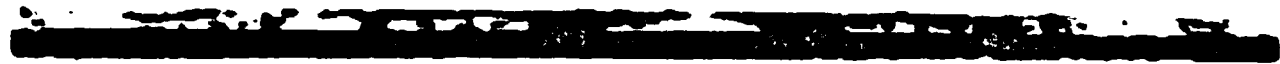
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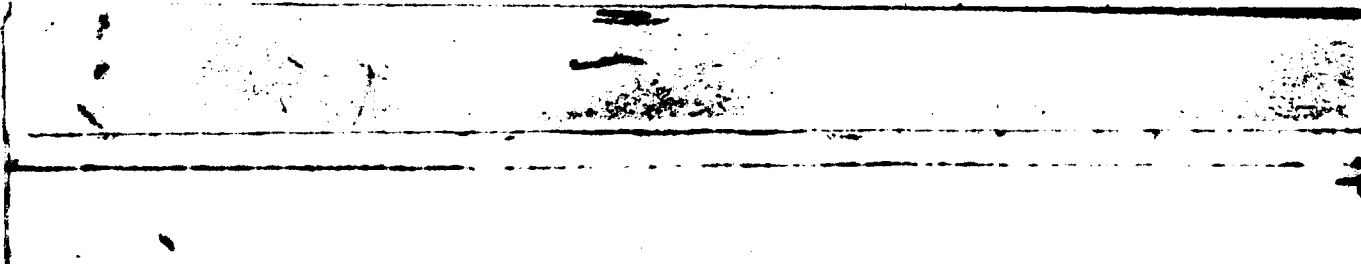
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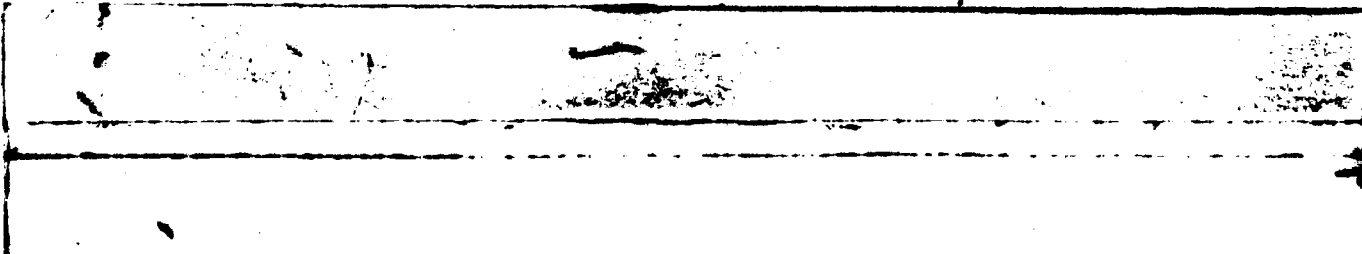
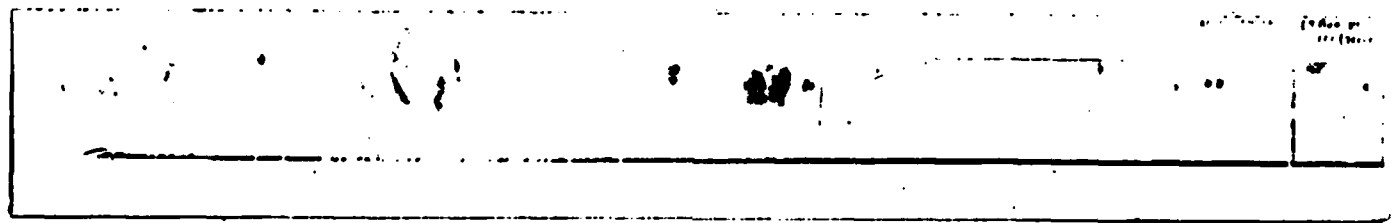
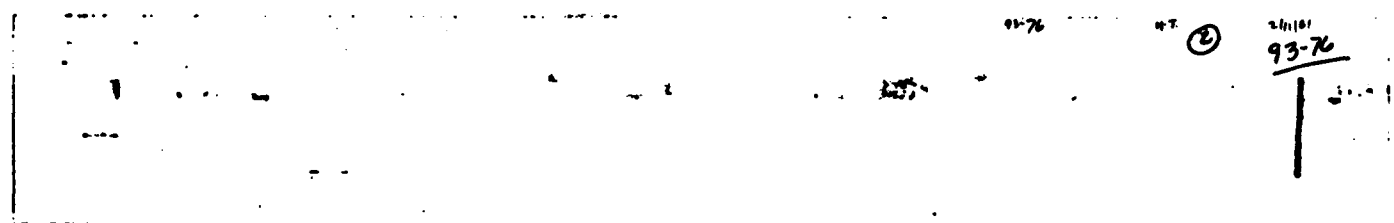
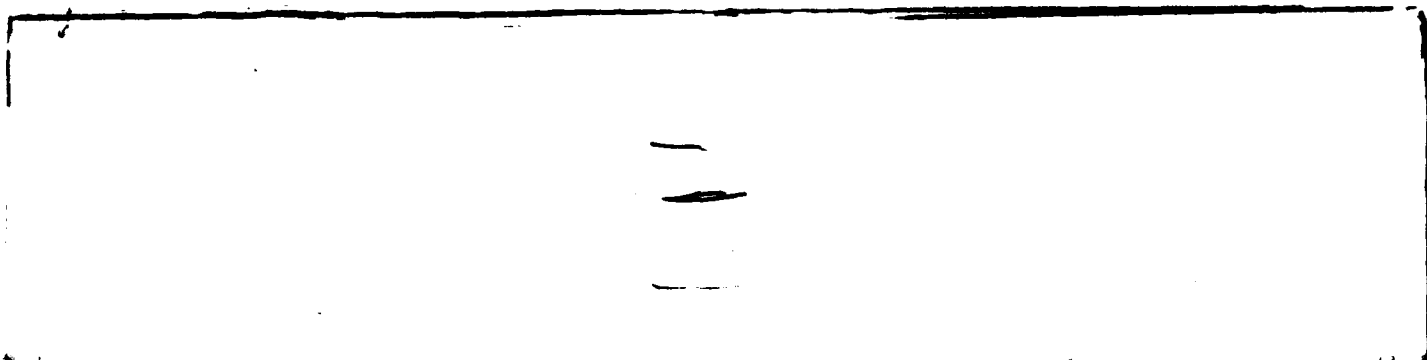
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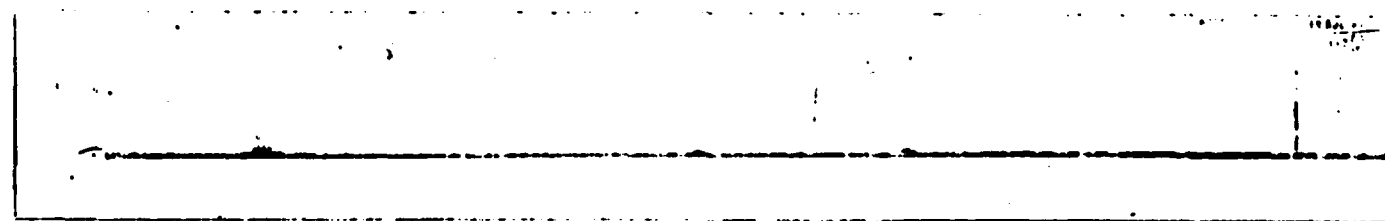
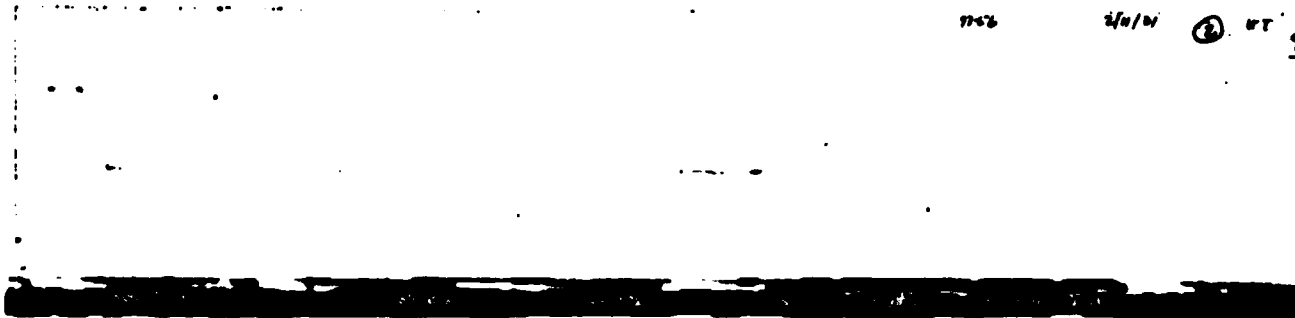
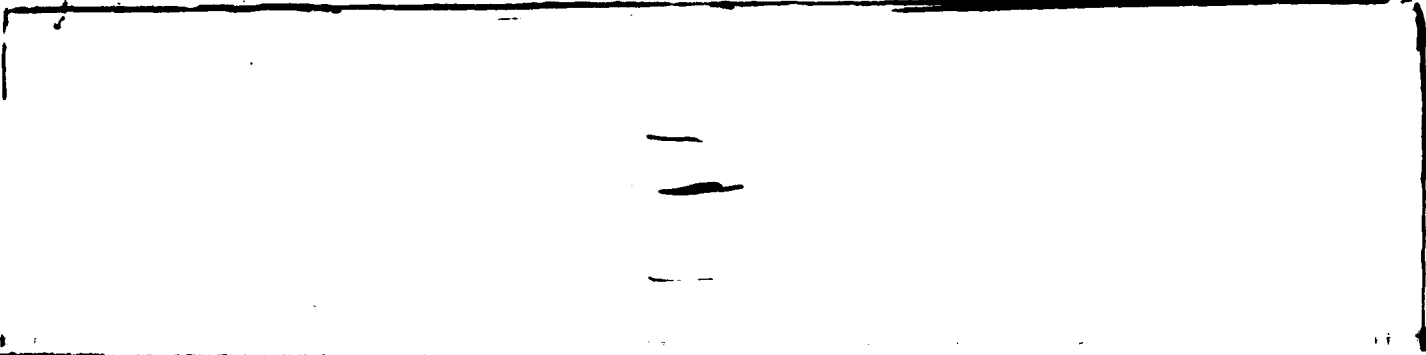


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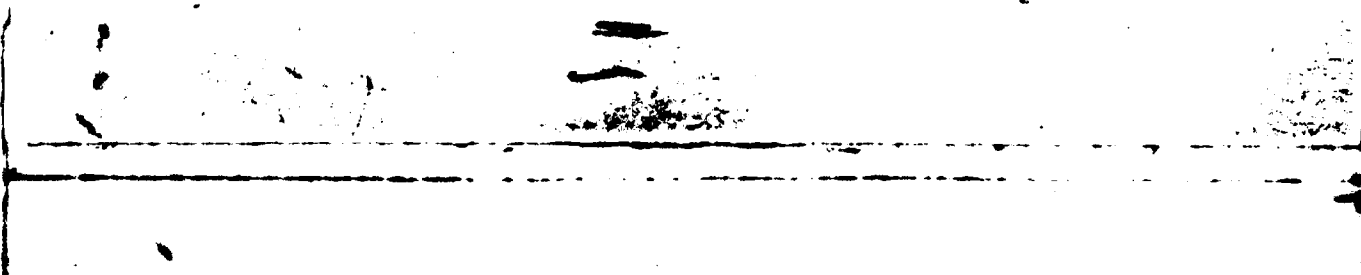
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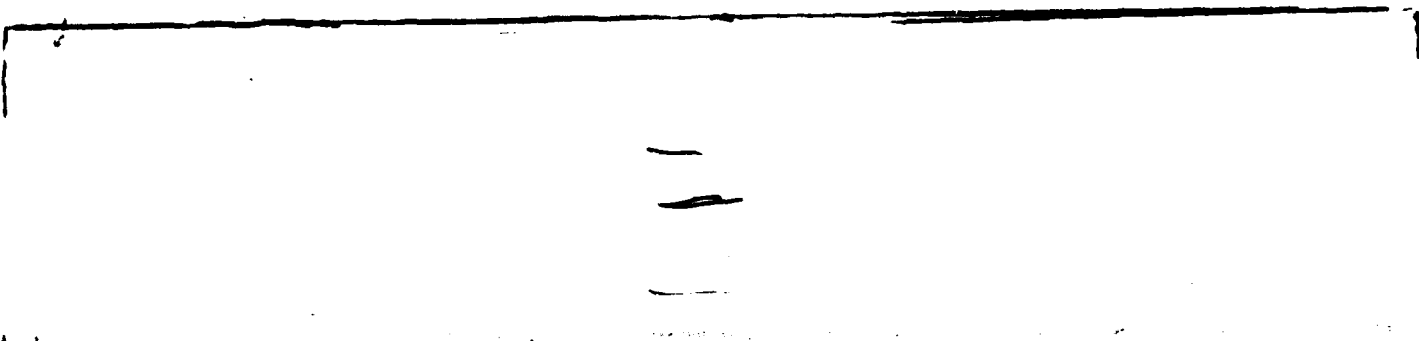
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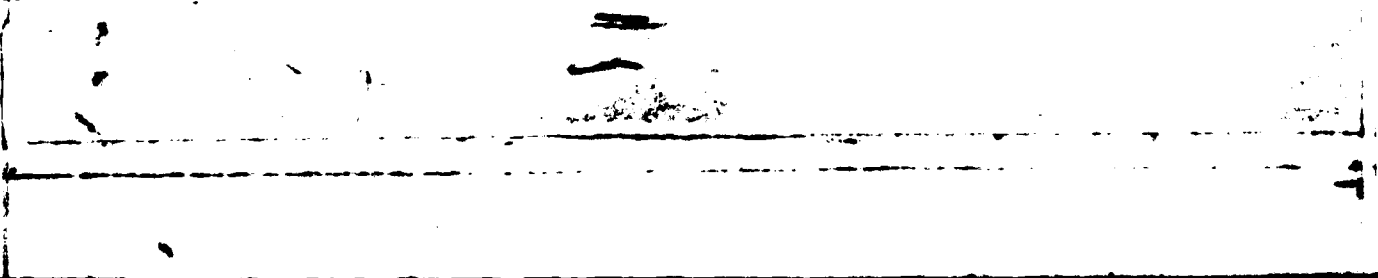


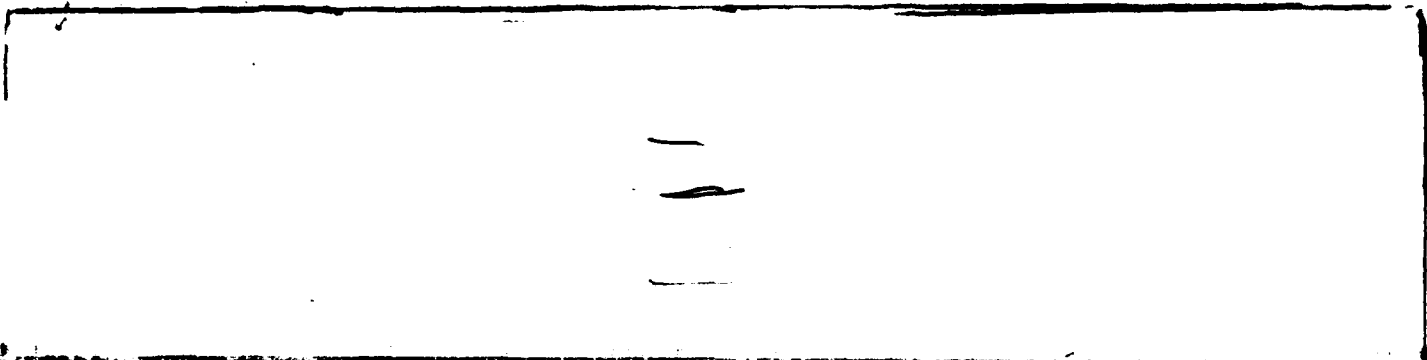


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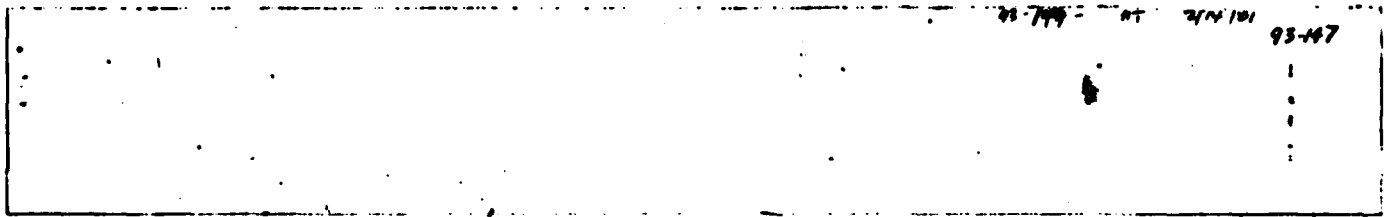
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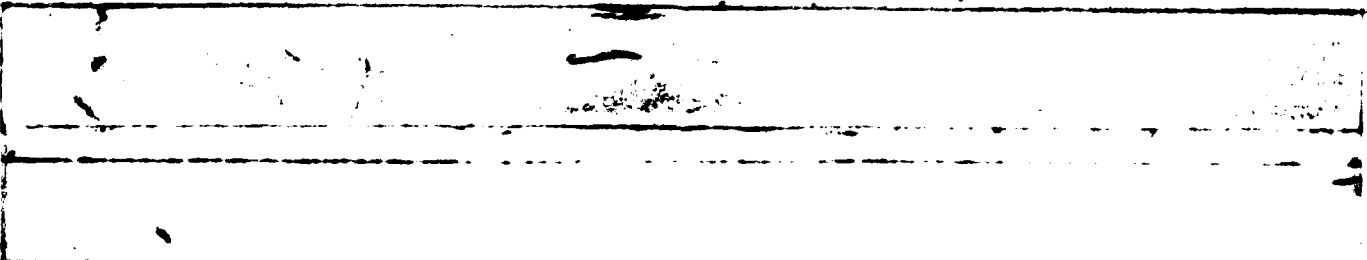


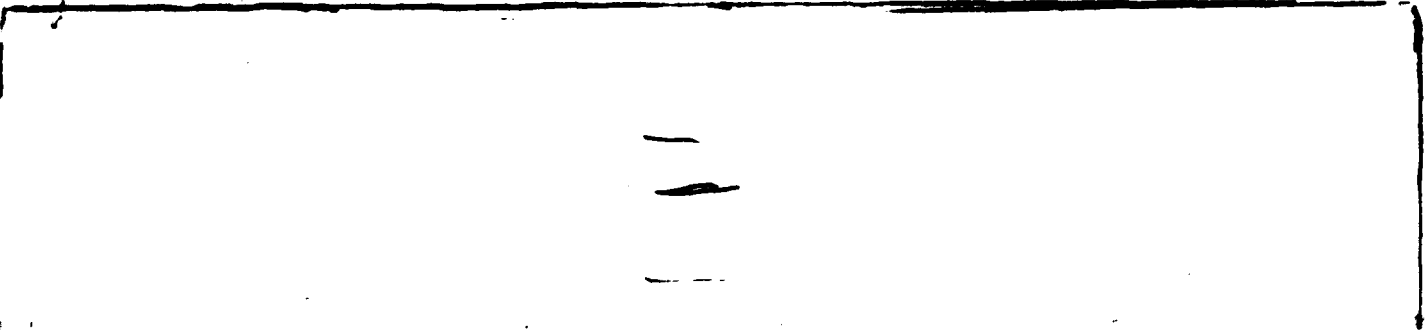


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98-44 73-44 47 4/10/01

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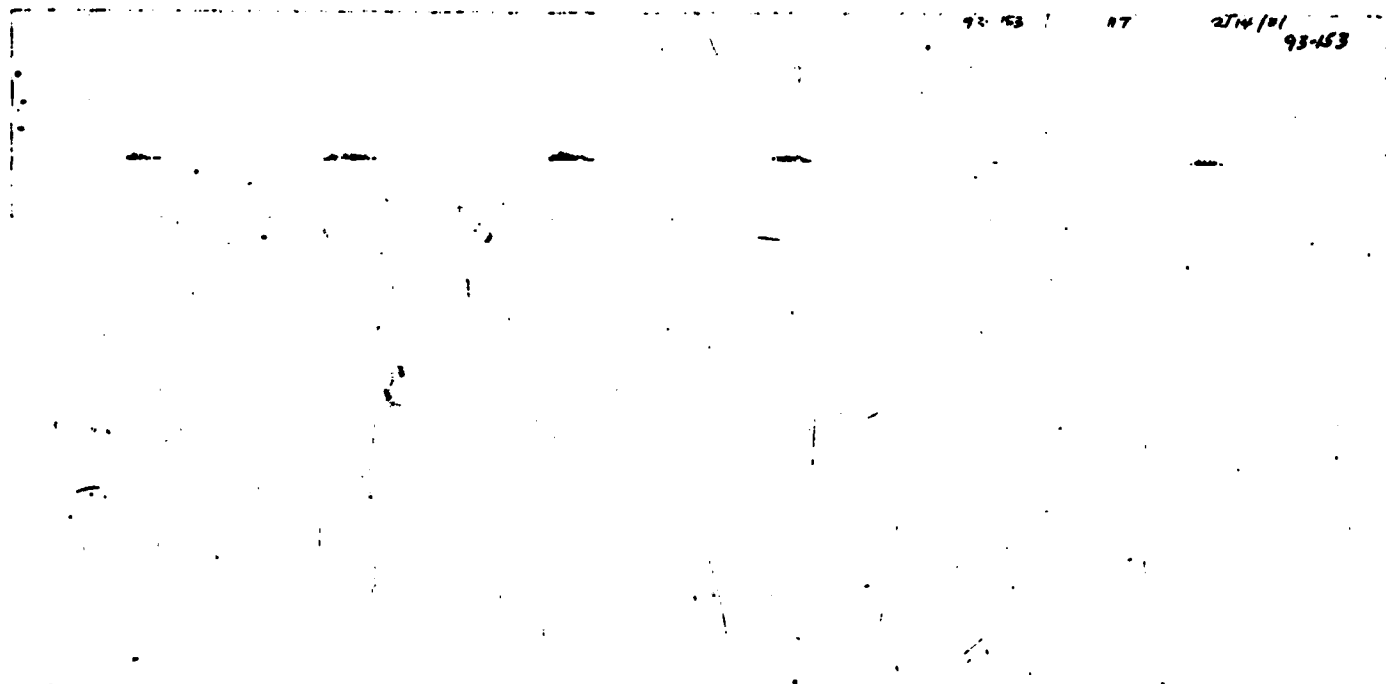


117 (22)

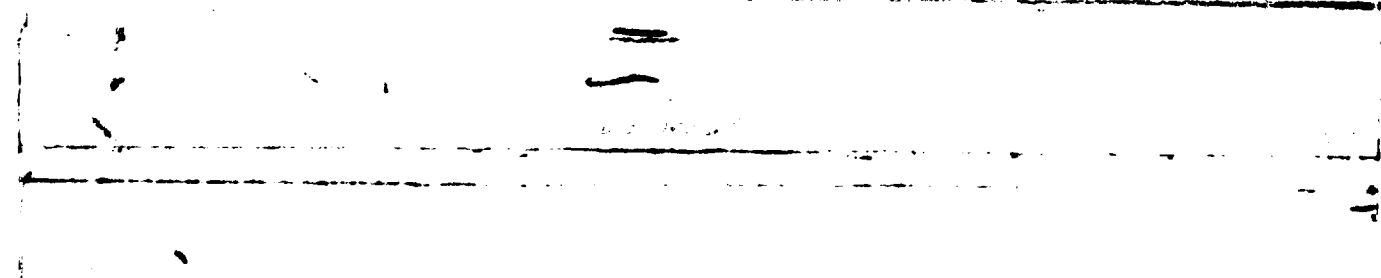
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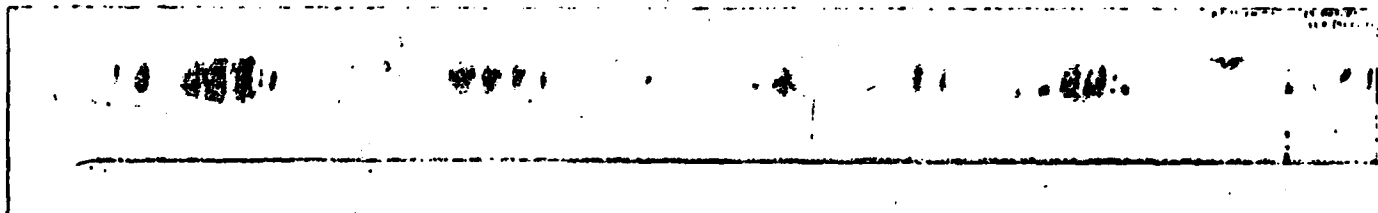
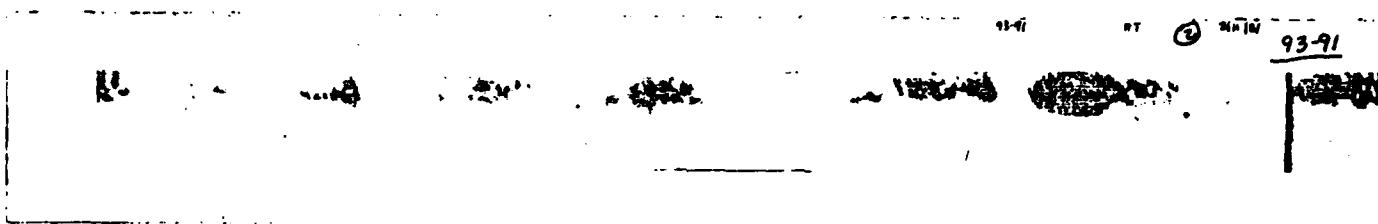


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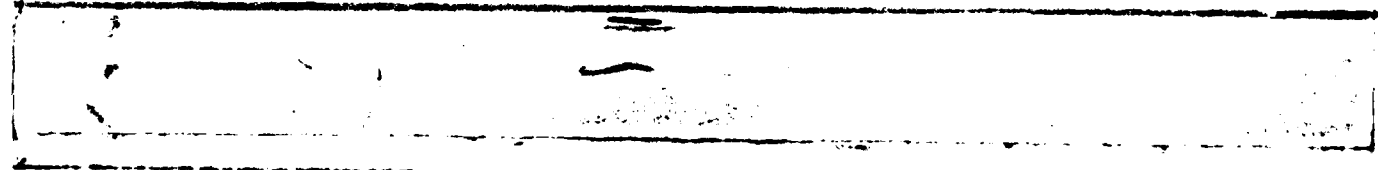




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